



(12) **United States Patent**
Brown et al.

(10) **Patent No.:** **US 9,265,672 B2**
(45) **Date of Patent:** ***Feb. 23, 2016**

(54) **METHODS AND APPARATUS FOR APPLYING ADHESIVES IN PATTERNS TO AN ADVANCING SUBSTRATE**

(56) **References Cited**

U.S. PATENT DOCUMENTS

(71) Applicant: **The Procter & Gamble Company**,
Cincinnati, OH (US)

2,531,036 A 7/1946 Goettsch
3,860,003 A 1/1975 Buell

(Continued)

(72) Inventors: **Darrell Ian Brown**, Mason, OH (US);
John Andrew Strasemeier, Aurora, IN (US)

FOREIGN PATENT DOCUMENTS

(73) Assignee: **The Procter & Gamble Company**,
Cincinnati, OH (US)

CN 2010 88947 7/2008
DE 88 02 807 UI 6/1988

(Continued)

(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

OTHER PUBLICATIONS

This patent is subject to a terminal disclaimer.

U.S. Appl. No. 13/685,844, filed Nov. 27, 2012—Office Action mailed Mar. 25, 2013, (13 pages).

(Continued)

(21) Appl. No.: **13/685,817**

Primary Examiner — Christopher Schatz

(22) Filed: **Nov. 27, 2012**

Assistant Examiner — Marta Dulko

(74) *Attorney, Agent, or Firm* — Charles R. Matson

(65) **Prior Publication Data**

US 2014/0148774 A1 May 29, 2014

(57) **ABSTRACT**

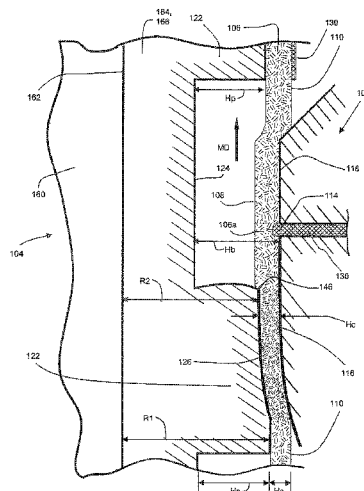
(51) **Int. Cl.**
B05D 5/10 (2006.01)
A61F 13/531 (2006.01)
A61F 13/15 (2006.01)
(Continued)

Aspects of the methods and apparatuses herein involve applying fluids onto an advancing substrate. The apparatuses and methods herein may provide for the application of viscous fluids, such as adhesives, in pre-determined patterns to an advancing substrate. The fluid application apparatus may include a slot die applicator and a substrate carrier. The slot die applicator may include a slot opening, a first lip, and a second lip, the slot opening located between the first lip and the second lip. And the substrate carrier may be adapted to advance the substrate past the slot die applicator as the slot die applicator discharges adhesive onto the substrate. In operation, when a first surface of the substrate is disposed on the substrate carrier, the substrate carrier advances a second surface of the substrate past the slot opening of the slot die applicator.

(52) **U.S. Cl.**
CPC **A61F 13/531** (2013.01); **A61F 13/15593** (2013.01); **B05C 5/0254** (2013.01); **B05C 1/0808** (2013.01); **B05C 11/1002** (2013.01)
(58) **Field of Classification Search**
CPC B05C 3/125; B05C 1/0808; B05C 5/0254; B05C 11/1034; A61F 13/531; A61F 13/15699; A61F 13/15593
USPC 156/227; 427/256, 207.1; 604/370; 118/419

See application file for complete search history.

7 Claims, 23 Drawing Sheets



Page 2

[illegible]

(56)

References Cited

FOREIGN PATENT DOCUMENTS

KR	2009-0101705	9/2009
WO	WO 1996/04874 A1	2/1996
WO	WO 00/76438 A2	12/2000
WO	WO 00/76443 A1	12/2000
WO	WO 2005/014263	2/2005
WO	WO 2006/098934 A1	9/2006
WO	WO 2008/038563	4/2008
WO	WO 2012/026330	3/2012

OTHER PUBLICATIONS

U.S. Appl. No. 13/434,984, filed Mar. 30, 2012, Uwe Schneider.
U.S. Appl. No. 13/435,036, filed Mar. 30, 2012, Uwe Schneider, et al.
U.S. Appl. No. 13/435,063, filed Mar. 30, 2012, Uwe Schneider, et al.
U.S. Appl. No. 13/435,247, filed Mar. 30, 2012, Gary Dean LaVon, et al.
U.S. Appl. No. 13/435,503, filed Mar. 30, 2012, Tina Brown, et al.
U.S. Appl. No. 13/685,844, filed Nov. 27, 2012, Darrell Ian Brown, et al.
U.S. Appl. No. 13/685,948, filed Nov. 27, 2012, Darrell Ian Brown, et al.

U.S. Appl. No. 13/685,959, filed Nov. 27, 2012, Darrell Ian Brown, et al.

PCT international Search Report, PCT/US2013/069381 dated Mar. 19, 2014, 11 pages.

U.S. Appl. No. 13/685,948, filed Nov. 27, 2012—Office Action mailed Jul. 15, 2013 (10 pages).

U.S. Appl. No. 13/685,948, filed Nov. 27, 2012—Office Action mailed Feb. 12, 2014 (12 pages).

U.S. Appl. No. 13/685,844, filed Nov. 27, 2012—Notice of Allowance mailed Nov. 6, 2014, (8 pages).

U.S. Appl. No. 13/685,844, filed Nov. 27, 2012—Office Action mailed Jul. 2, 2013 (10 pages).

U.S. Appl. No. 13/685,959, filed Nov. 27, 2012—Office Action mailed Jan. 13, 2015, (9 pages).

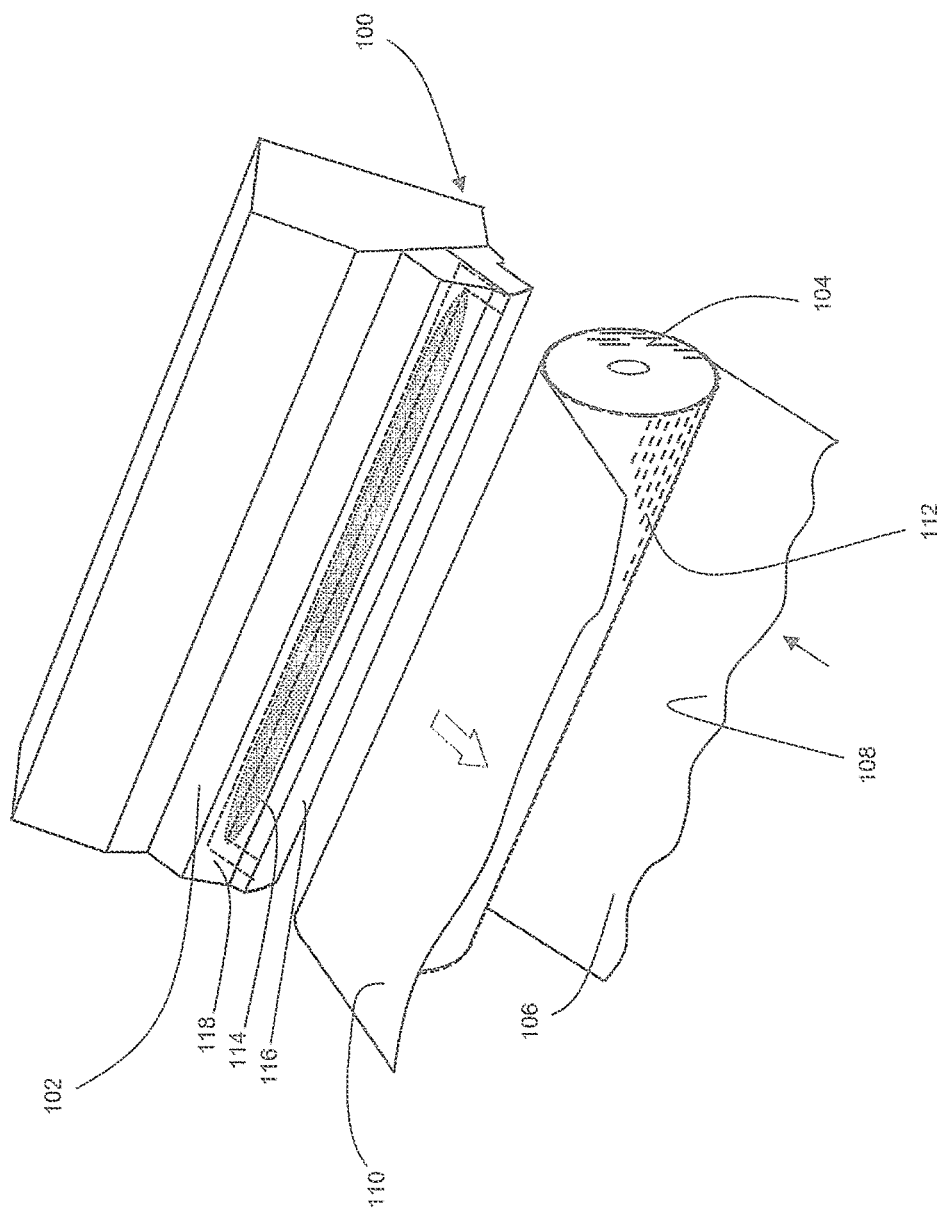
U.S. Appl. No. 13/685,948, filed Nov. 27, 2012—Office Action mailed Feb. 4, 2015 (11 pages).

U.S. Appl. No. 13/685,844, filed Nov. 27, 2012—Notice of Allowance mailed May 22, 2015 (6 pages).

U.S. Appl. No. 13/685,948, filed Nov. 27, 2012—Office Action mailed May 21, 2015 (11 pages).

U.S. Appl. No. 13/685,959, filed Nov. 27, 2012—Office Action mailed Jul. 23, 2015, (11 pages).

* cited by examiner



Length

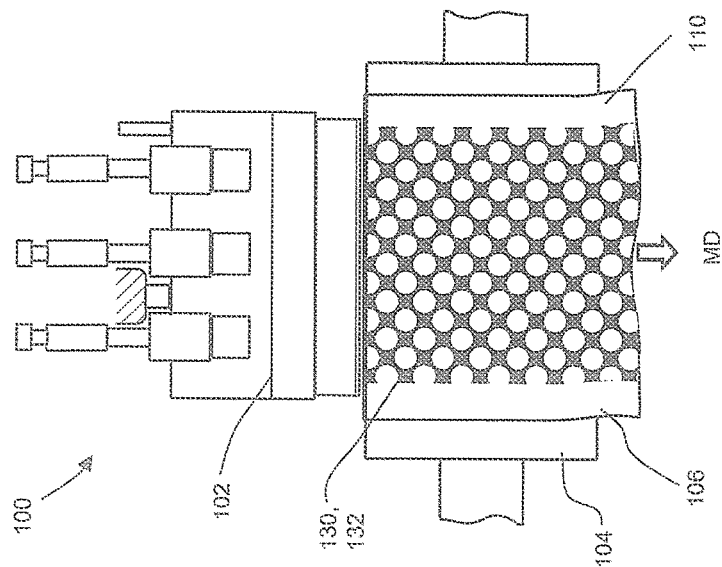


Figure 1B

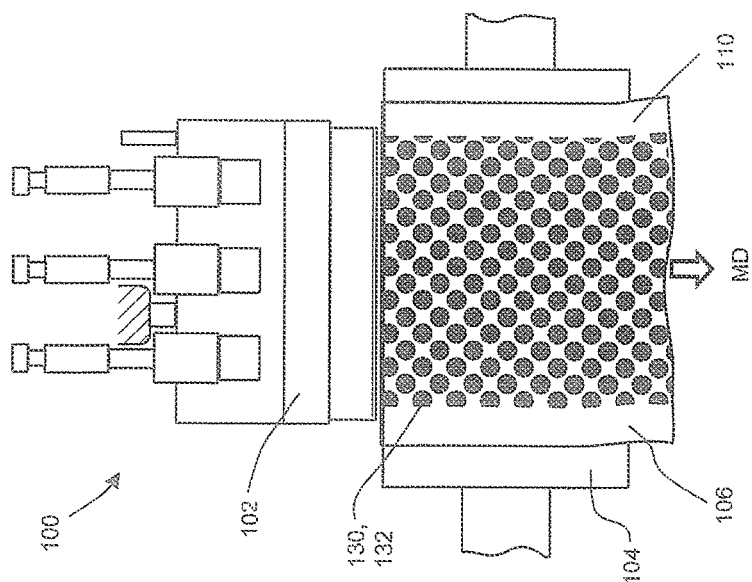


Figure 1A

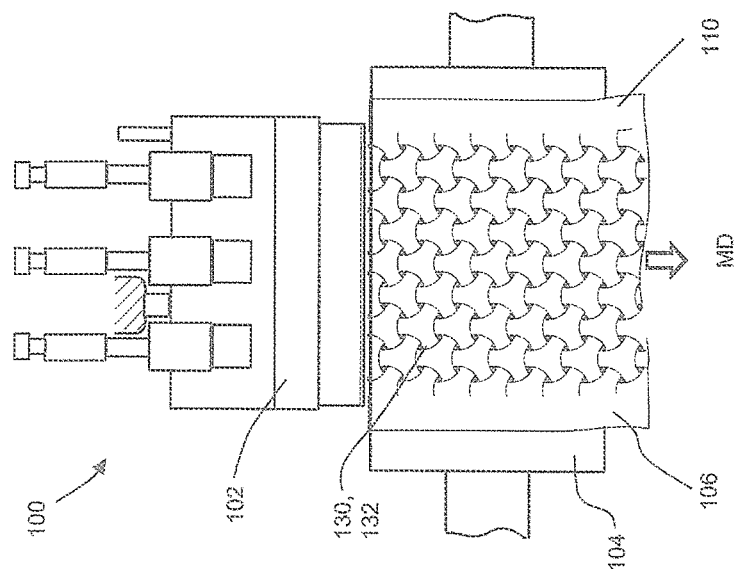


Figure 1D

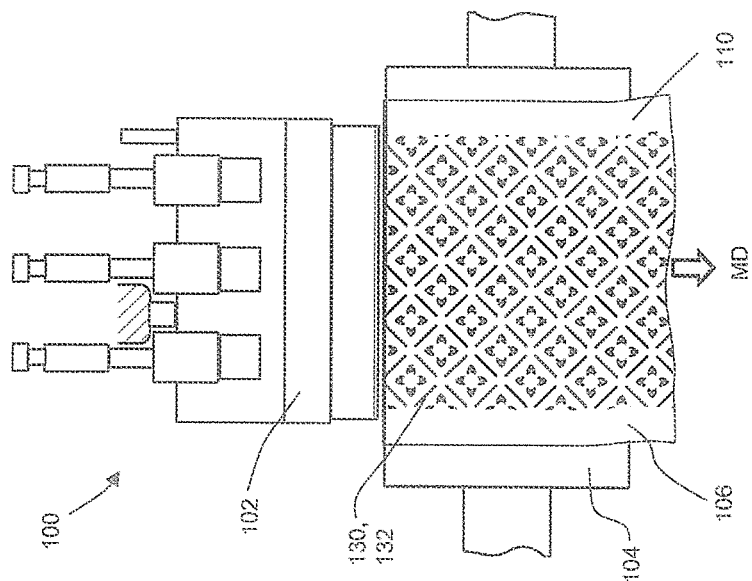


Figure 1C

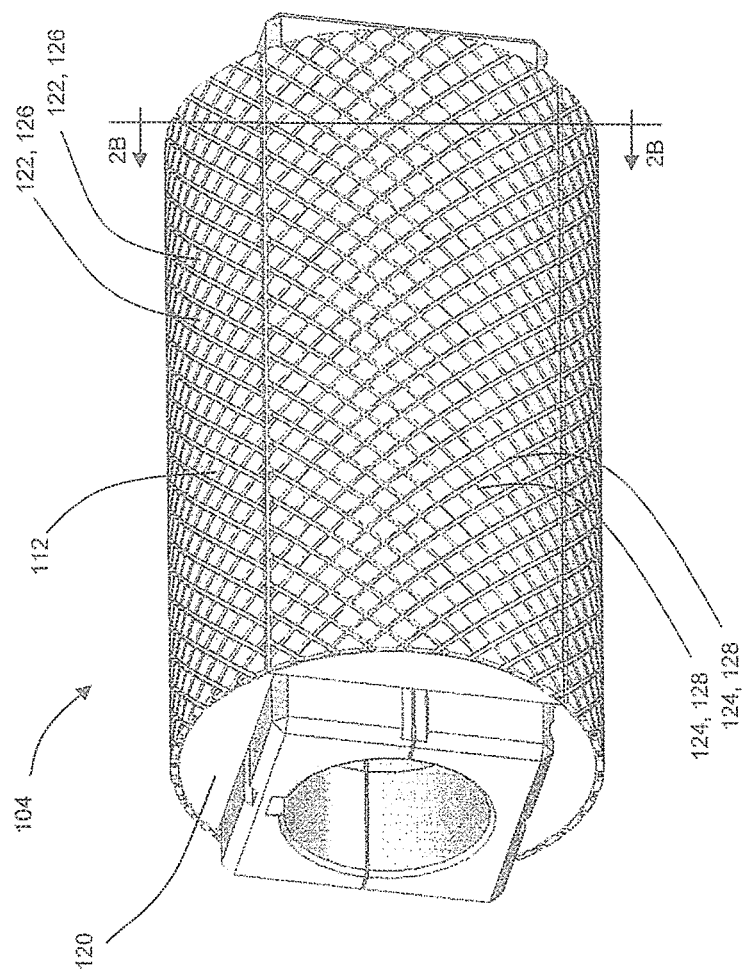


Figure 2A

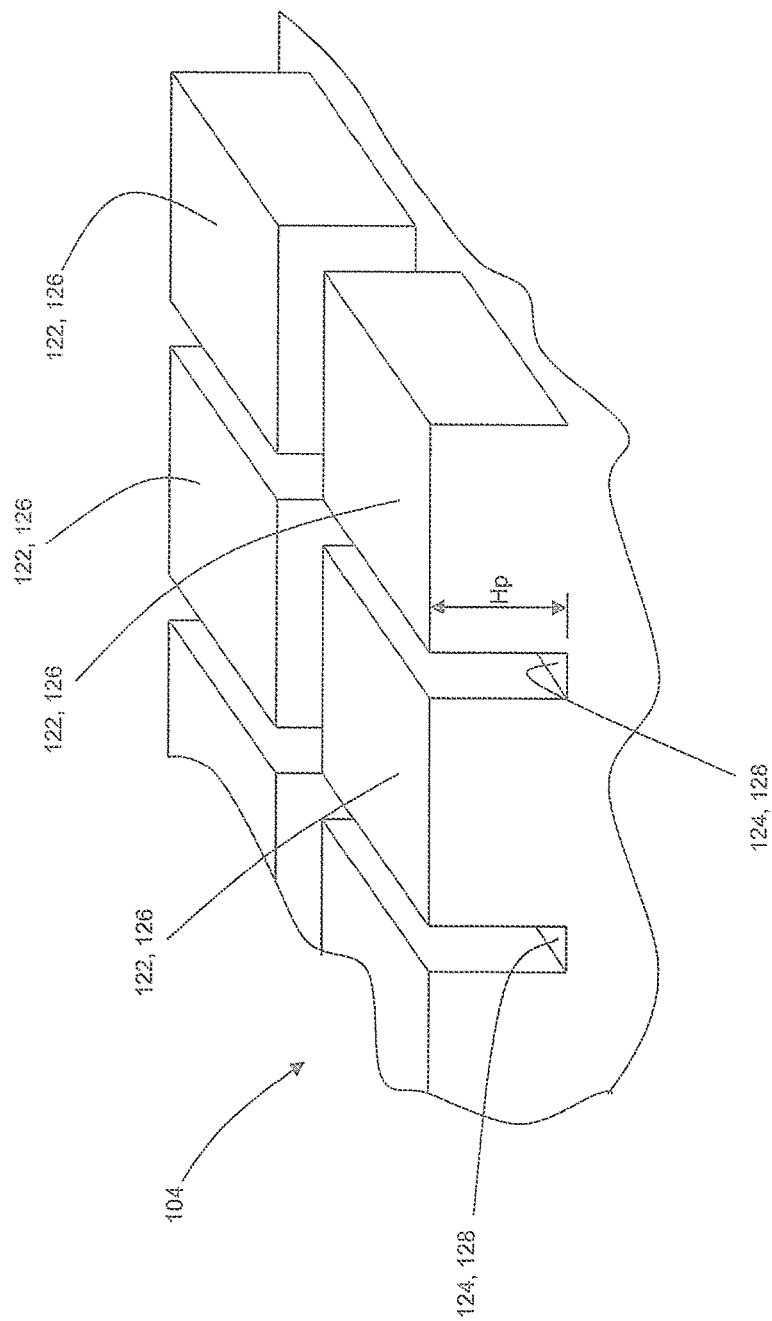


Figure 2B

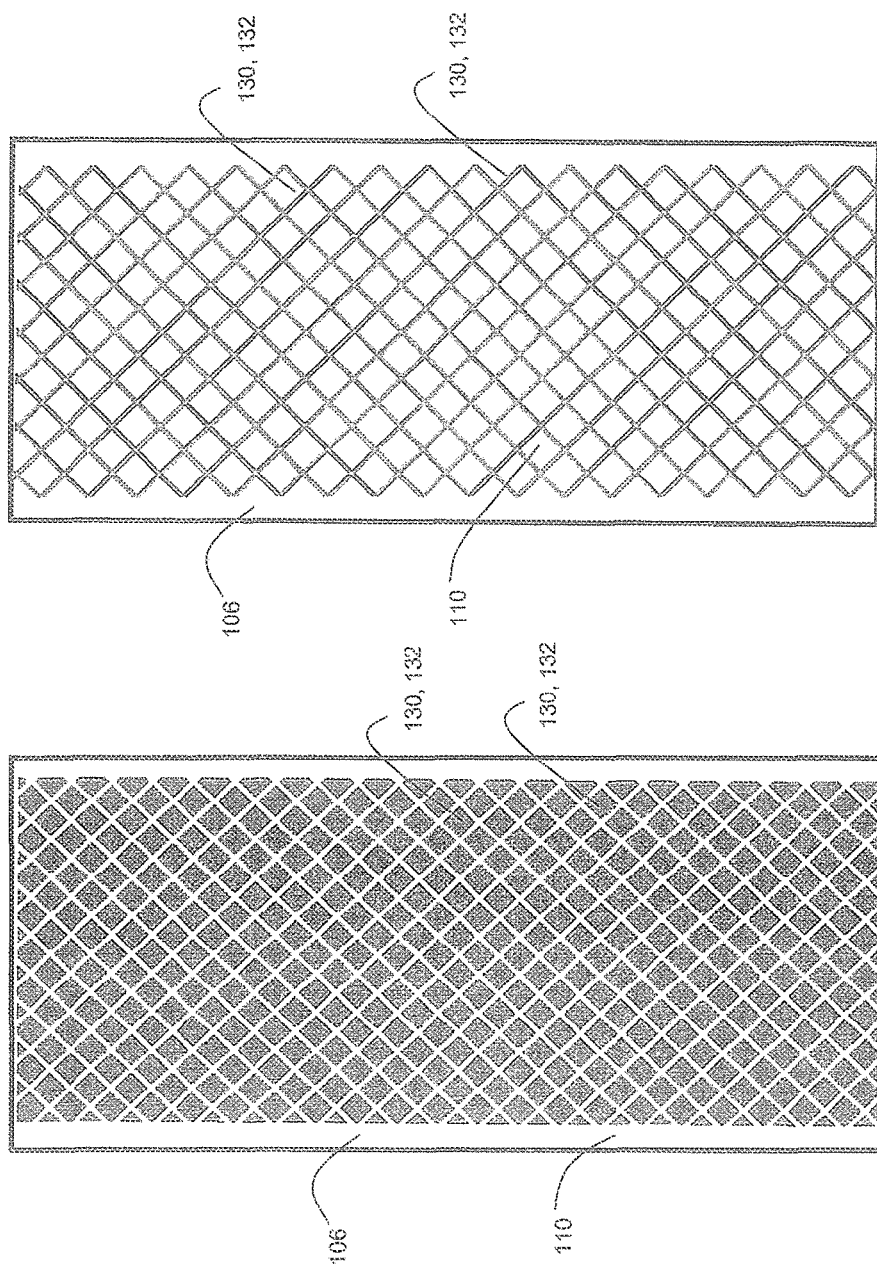


Figure 3C

Figure 2C

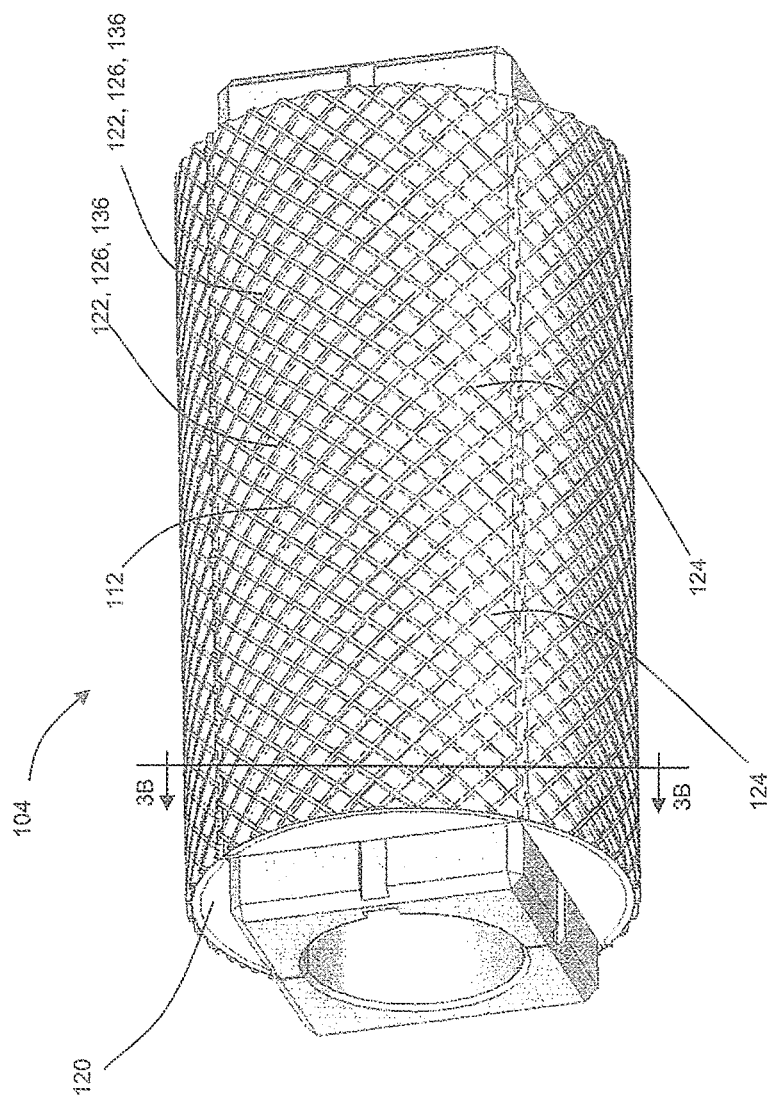


Figure 3A

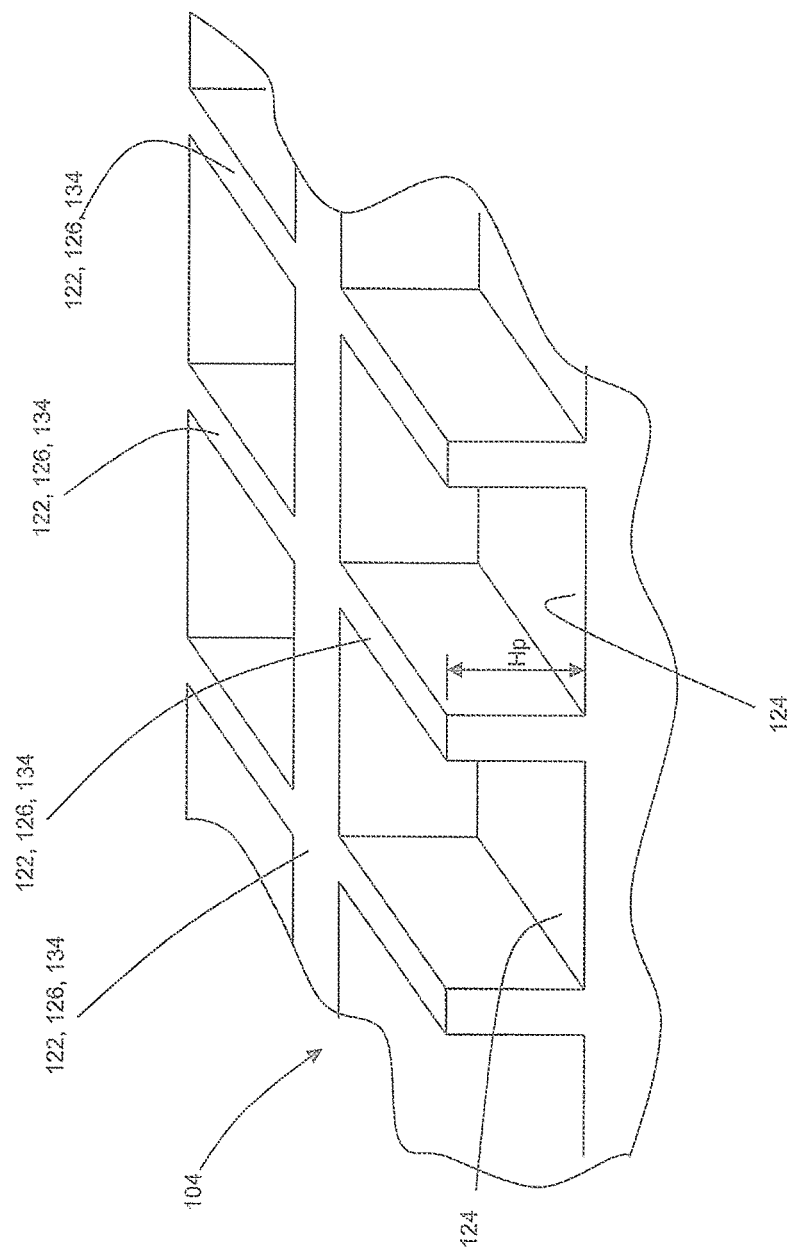


Figure 3B

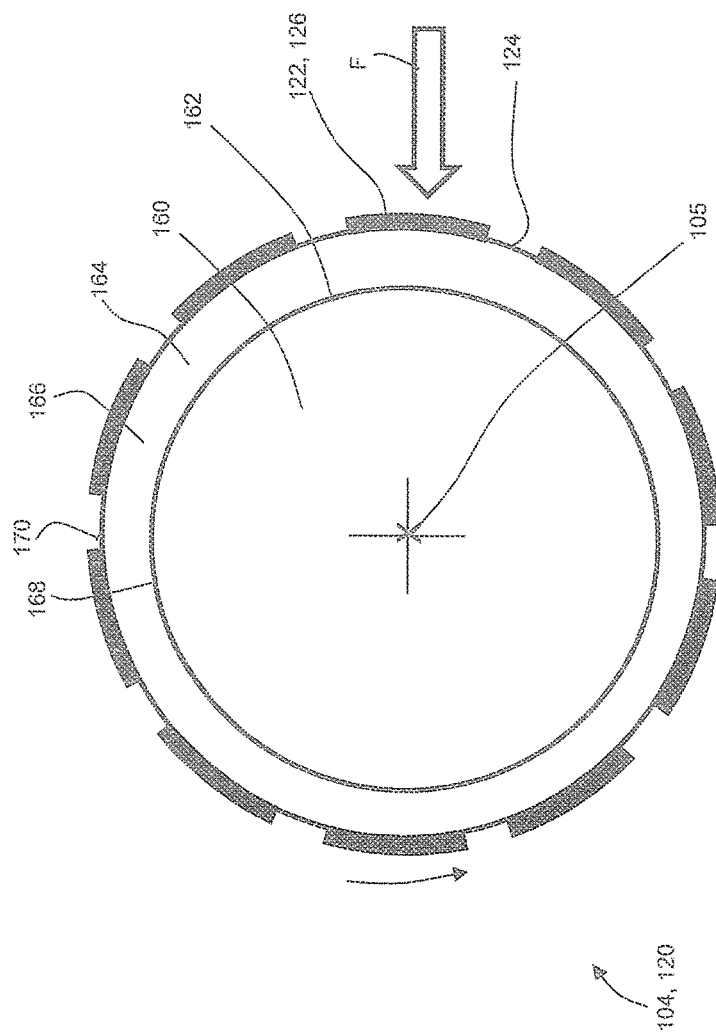


Figure 4

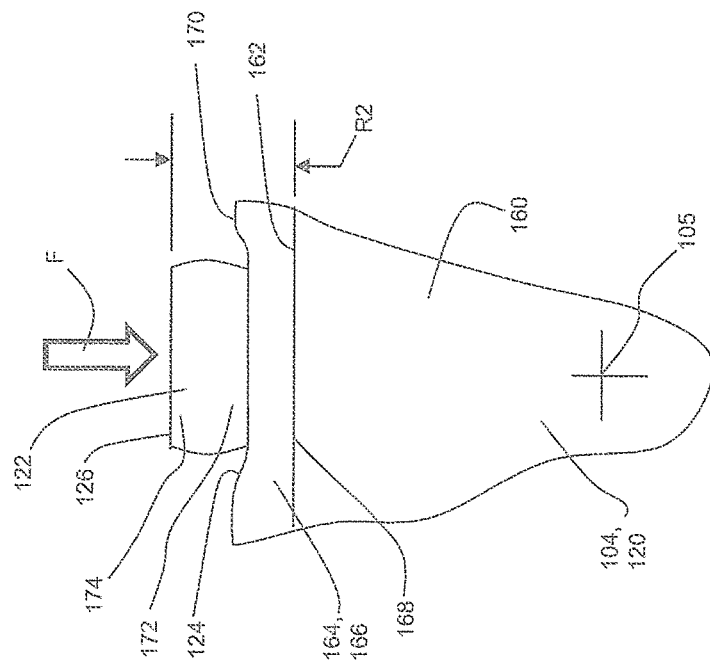


Figure 4A2

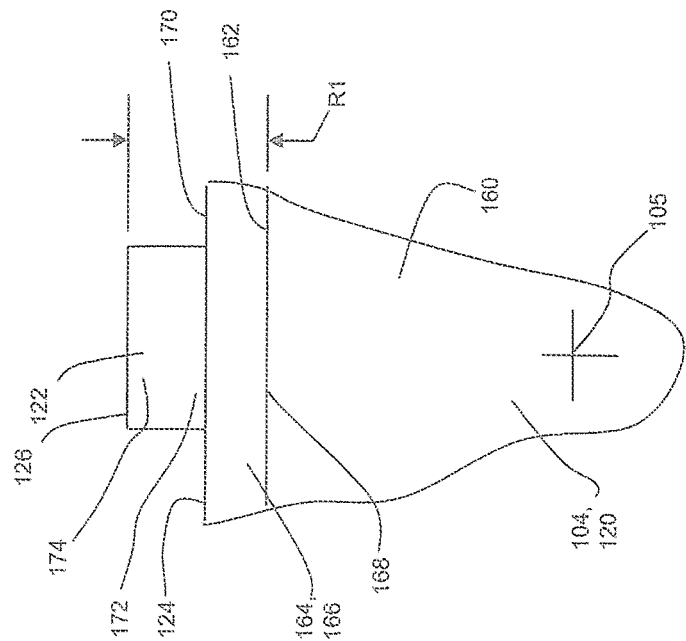


Figure 4A1

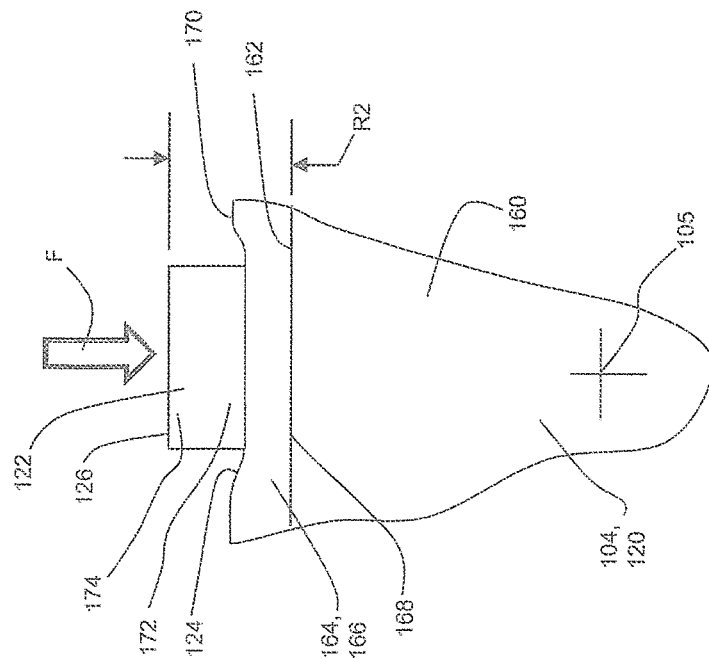


Figure 4B2

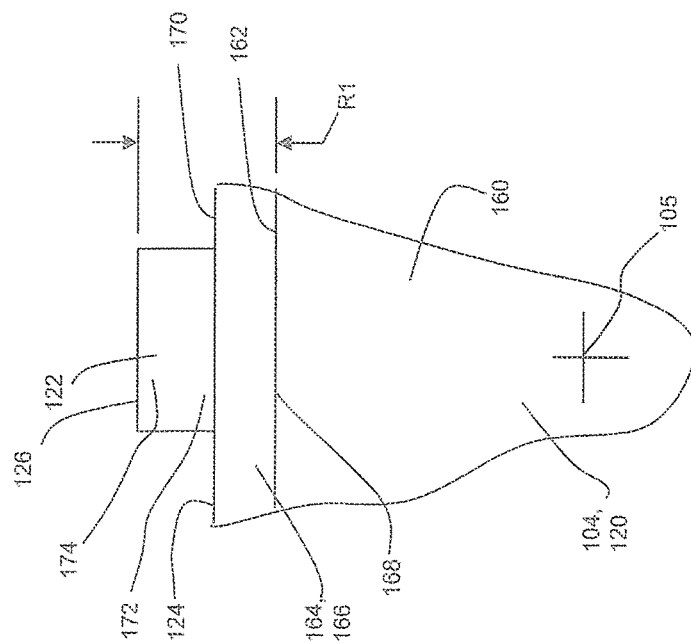


Figure 4B1

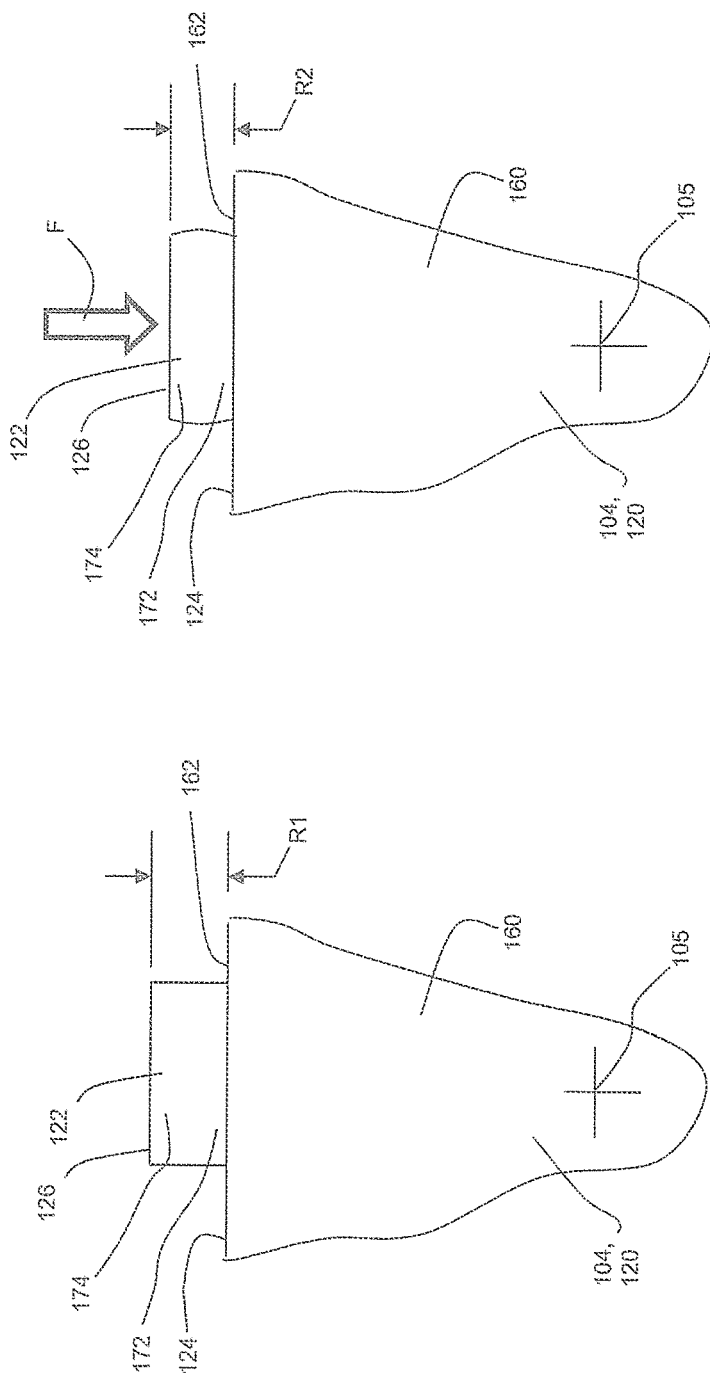


Figure 4C2

Figure 4C1

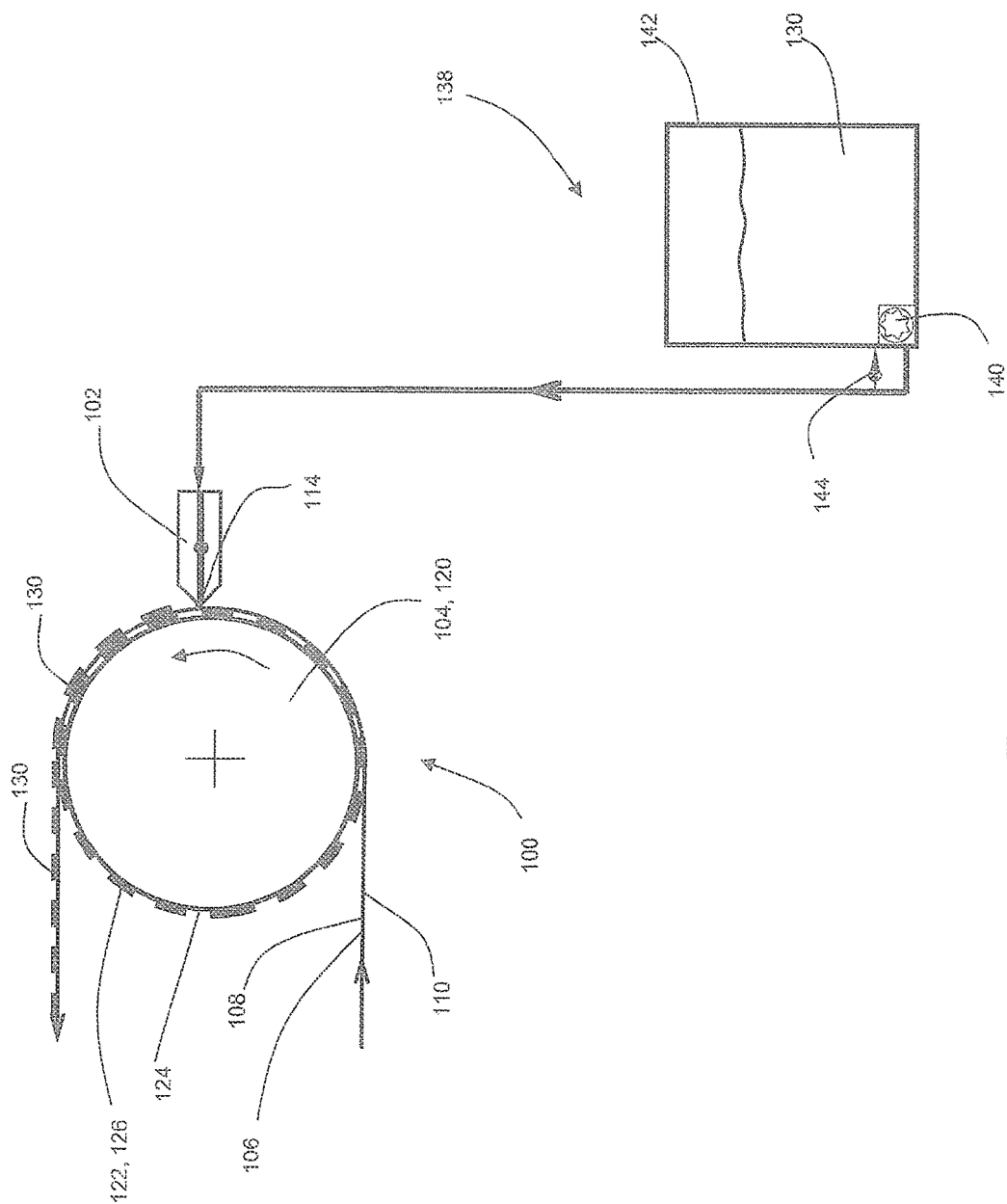


Figure 5

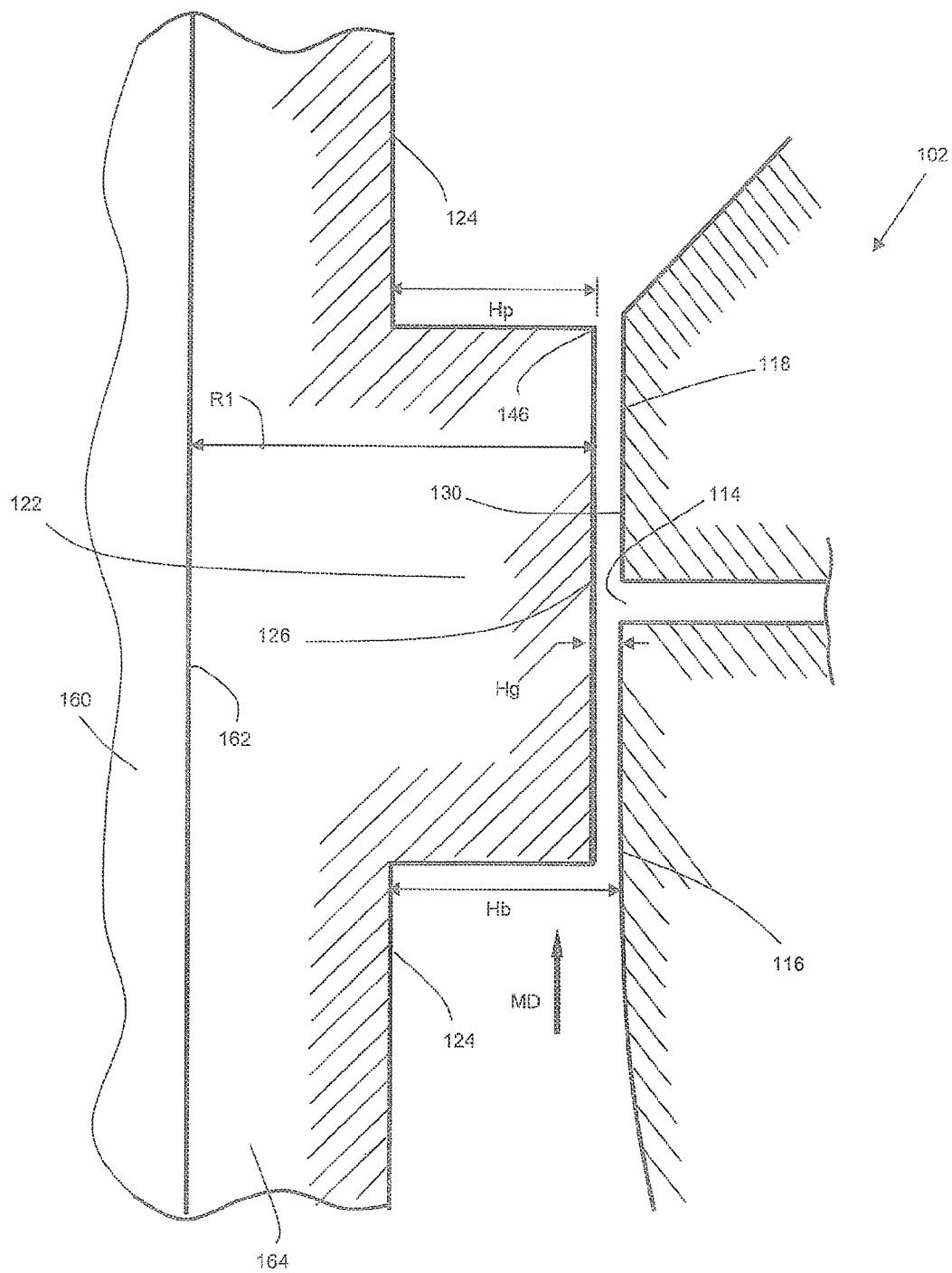


Figure 6A

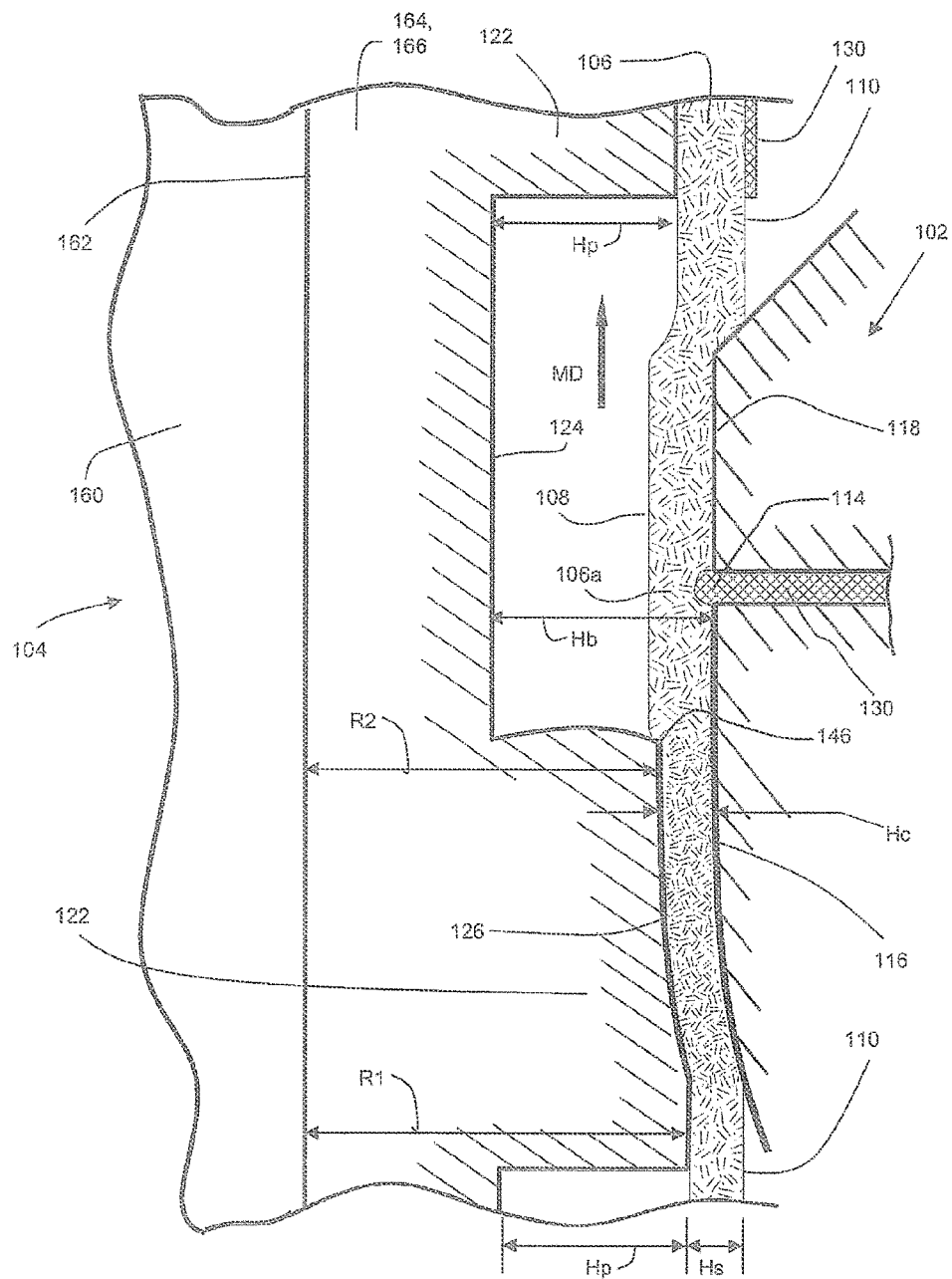


Figure 6B

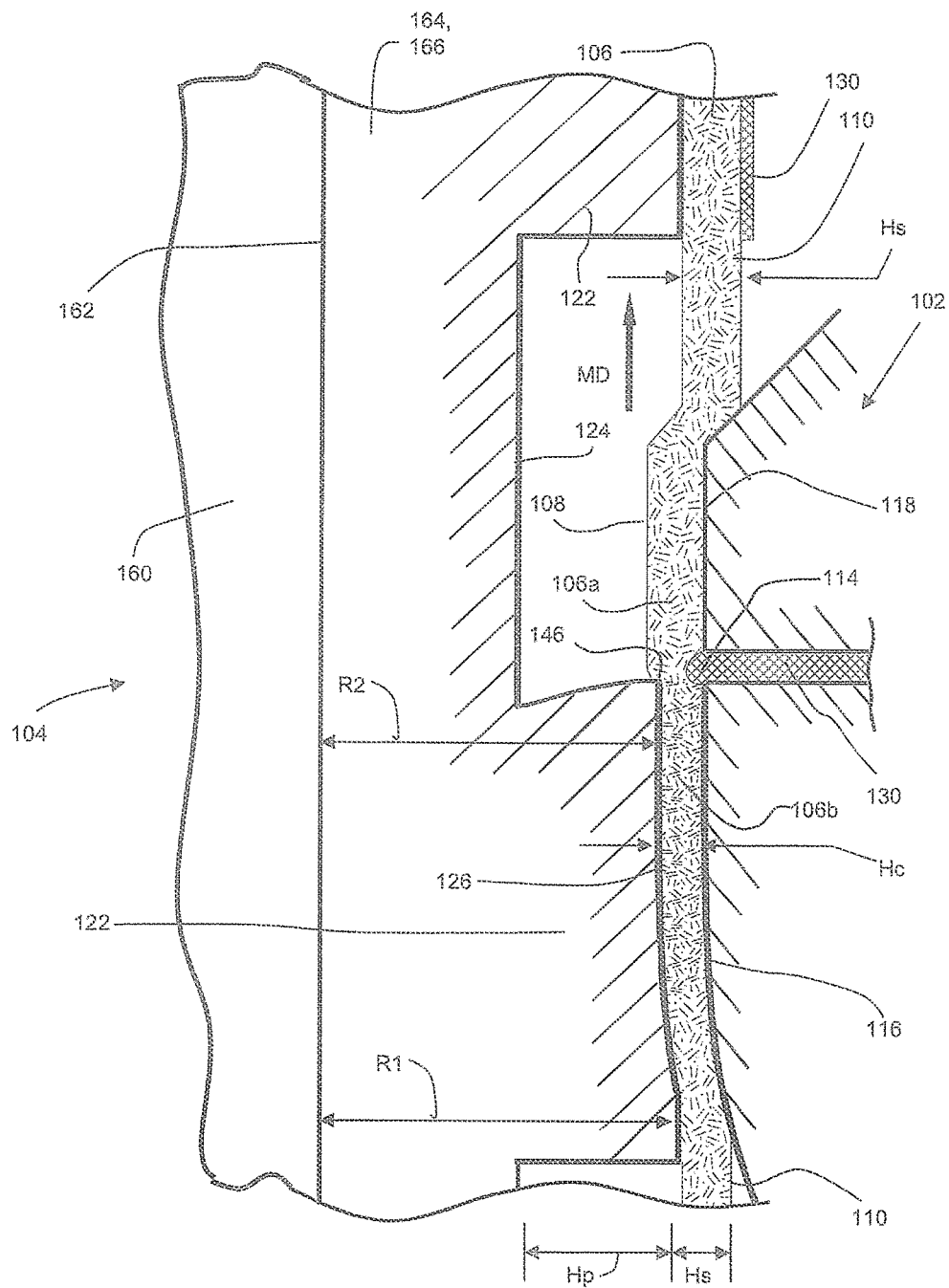


Figure 6C

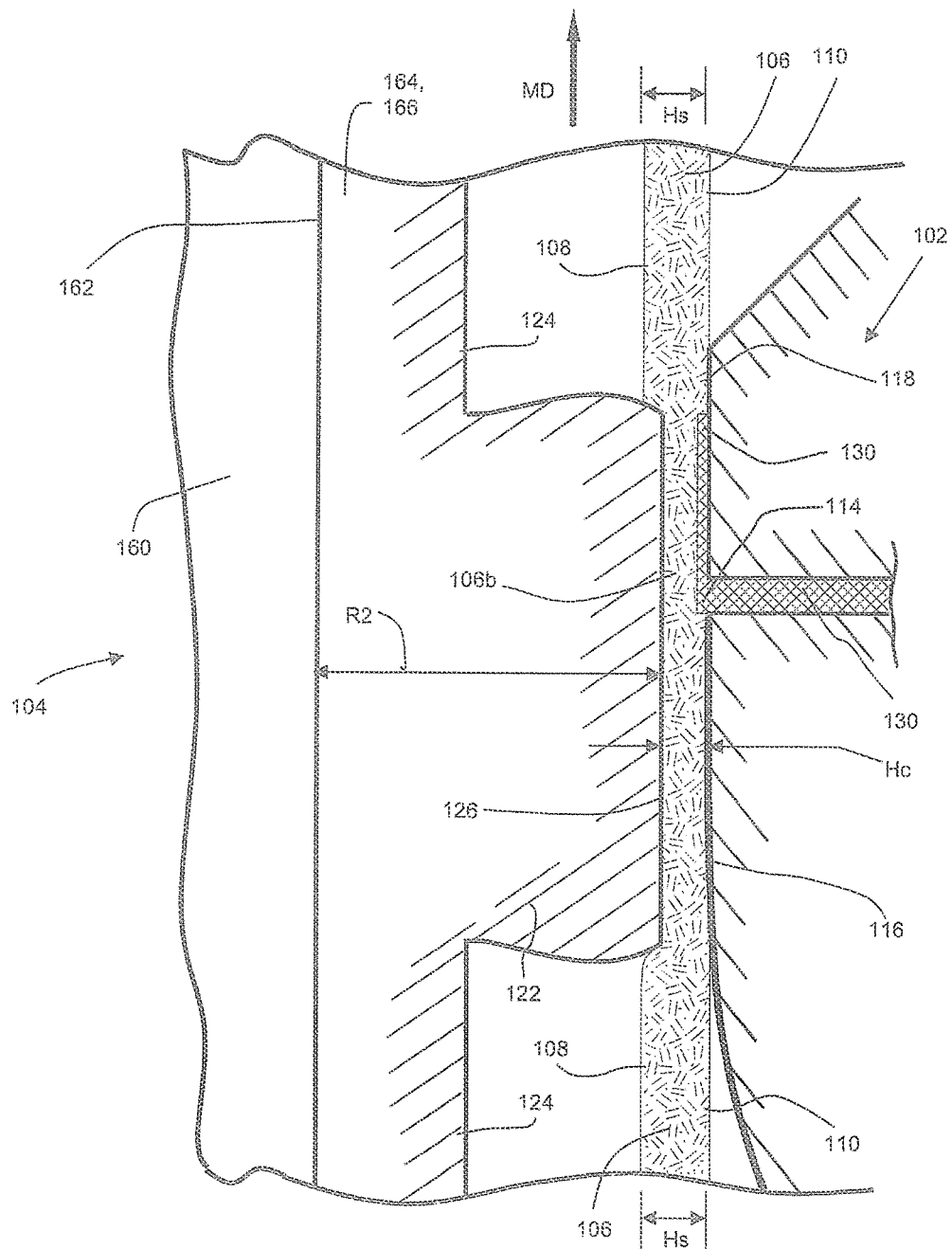


Figure 6D

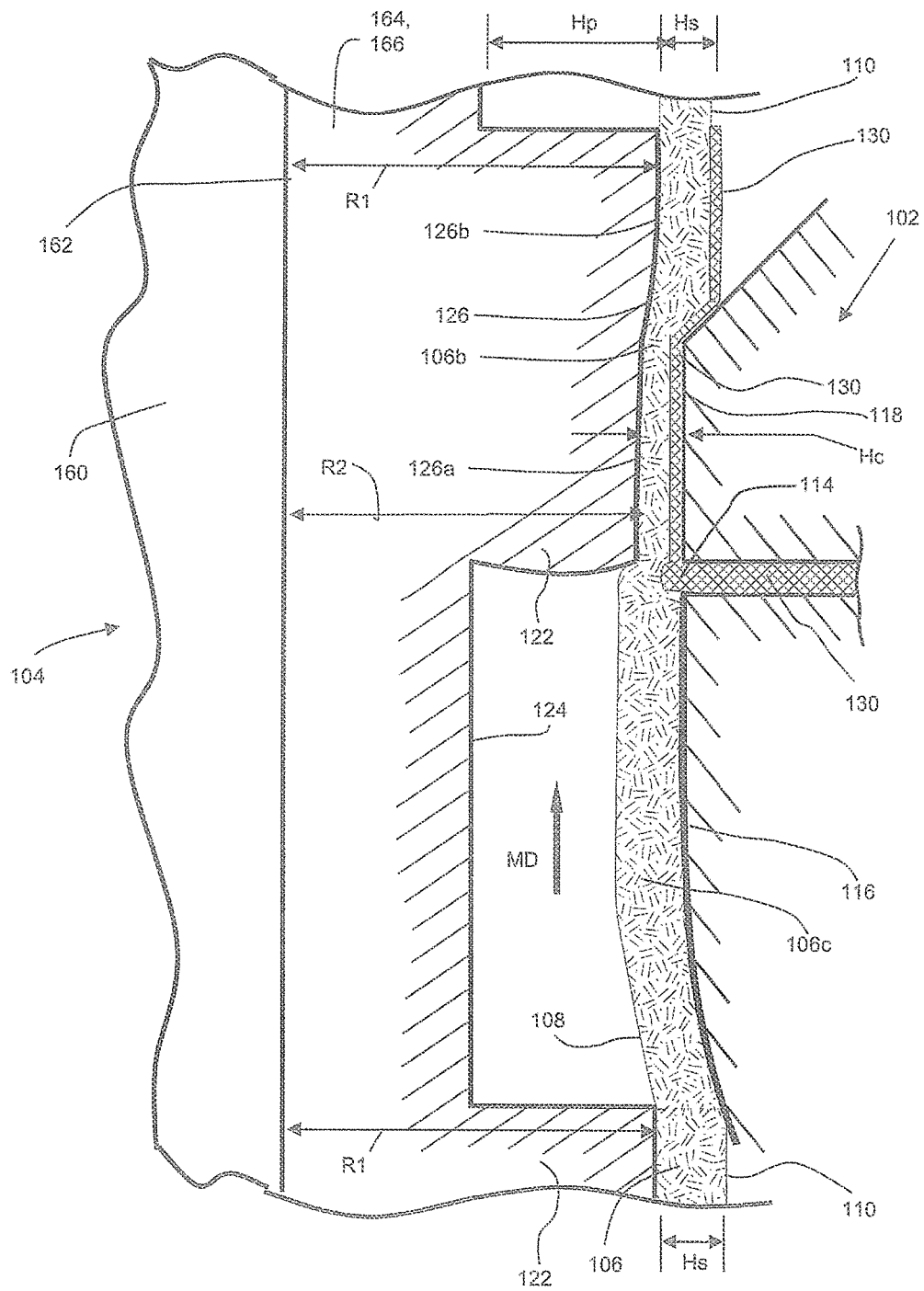


Figure 6E

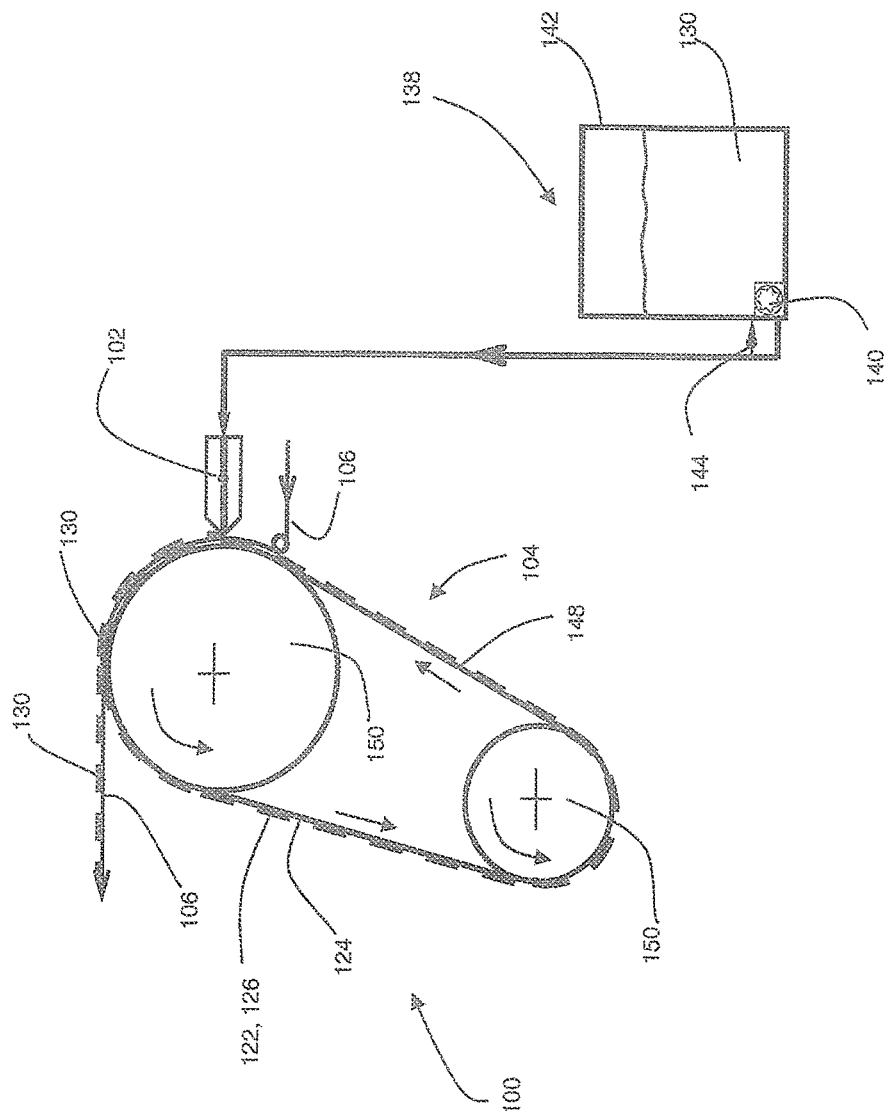


Figure 7

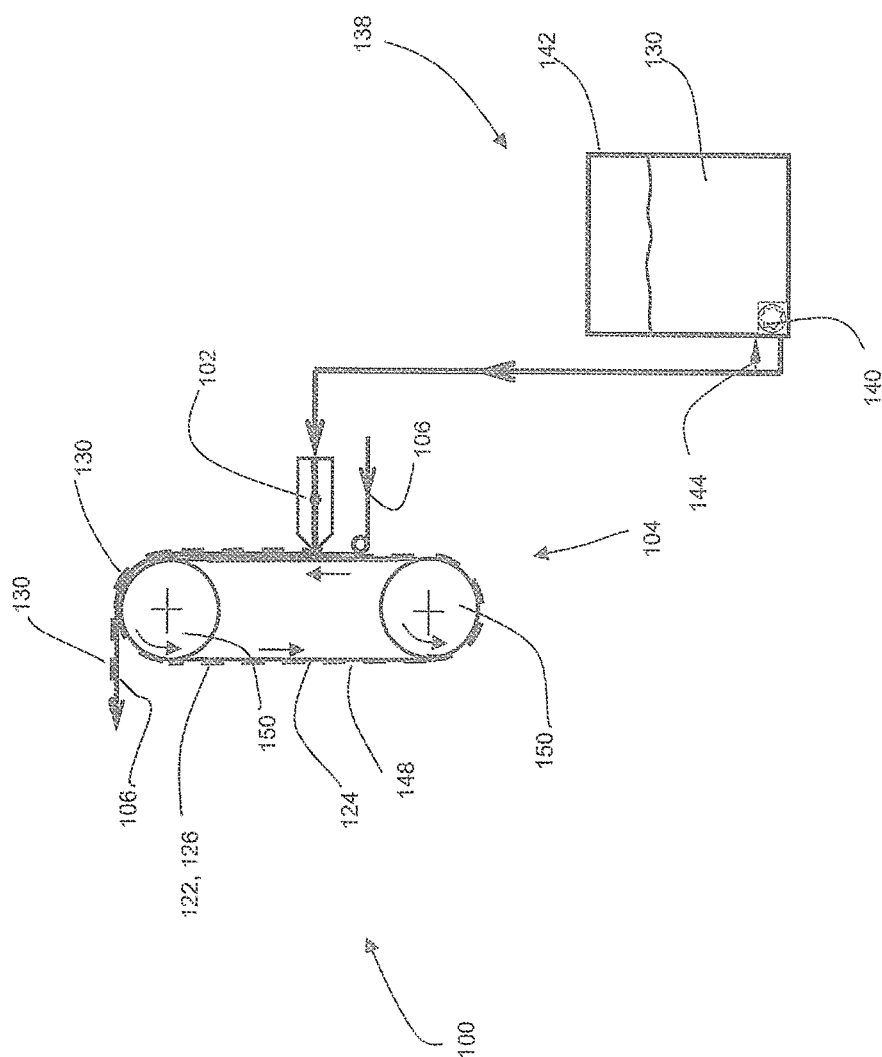


Figure 8

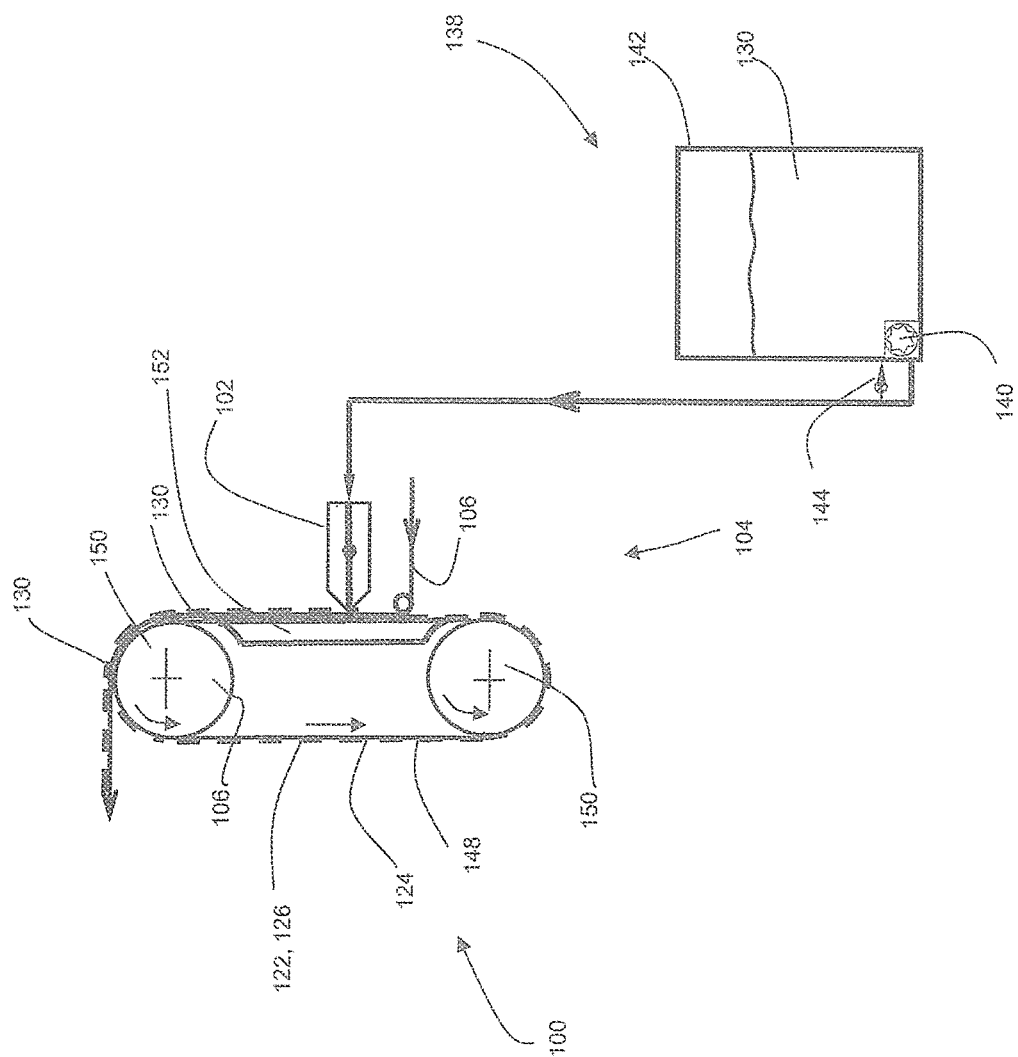


Figure 9

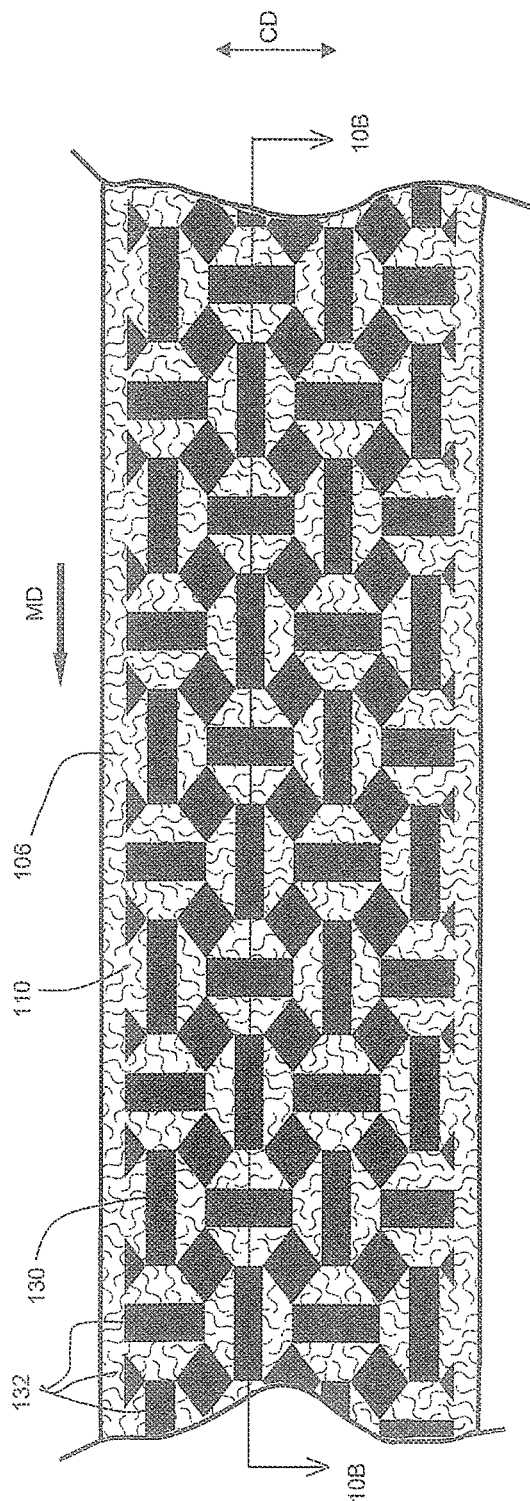


Figure 10A

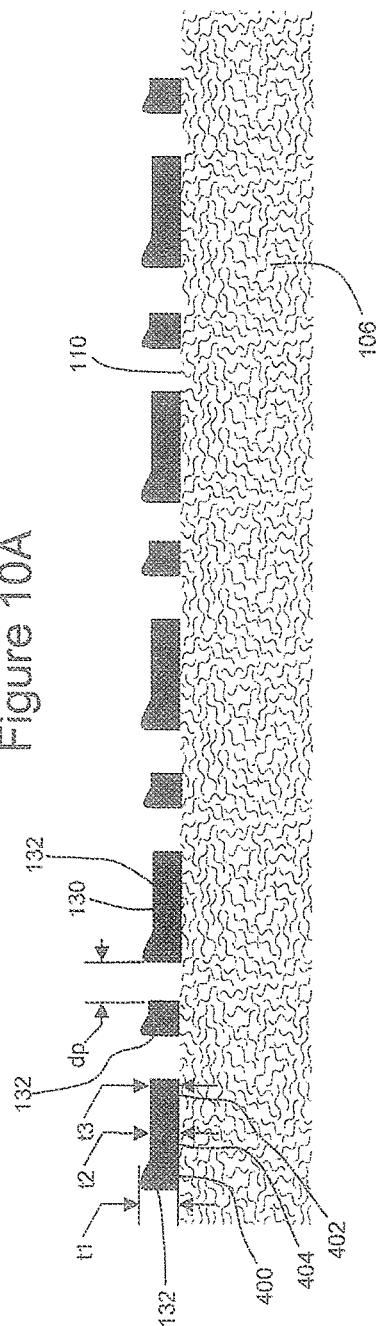


Figure 10B

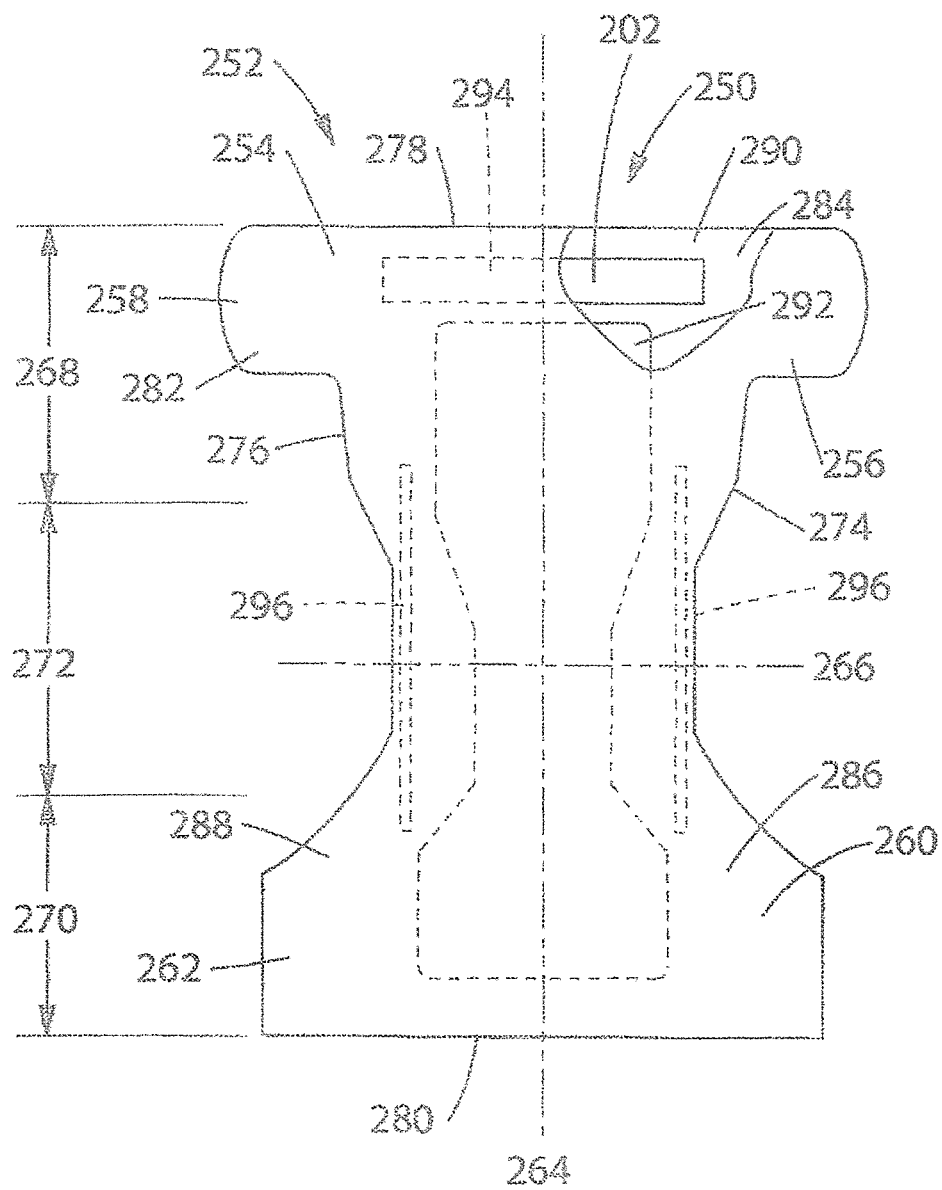


Fig. 11

1

METHODS AND APPARATUS FOR APPLYING ADHESIVES IN PATTERNS TO AN ADVANCING SUBSTRATE

FIELD OF THE INVENTION

The present disclosure relates to methods and apparatuses utilizing continuous substrates for manufacturing articles, and more particularly, methods and apparatuses for applying viscous fluid, such as adhesives, to an advancing substrate.

BACKGROUND OF THE INVENTION

Along an assembly line, various types of articles, such as for example, diapers and other absorbent articles, may be assembled by adding components to and otherwise modifying an advancing, continuous web of material. For example, in some processes, advancing webs of material are combined with other advancing webs of material. In other examples, individual components created from advancing webs of material are combined with advancing webs of material, which in turn, are then combined with other advancing webs of material. Webs of material and component parts used to manufacture diapers may include: backsheet, topsheet, absorbent cores, front and/or back ears, fastener components, and various types of elastic webs and components such as leg elastics, barrier leg cuff elastics, and waist elastics. Once the desired component parts are assembled, the advancing web(s) and component parts are subjected to a final knife cut to separate the web(s) into discrete diapers or other absorbent articles. The discrete diapers or absorbent articles may also then be folded and packaged.

Various methods and apparatuses may be used for attaching different components to the advancing web and/or otherwise modify the advancing web. For example, some production operations are configured to apply relatively high viscosity fluids, such as hot melt adhesives, to an advancing web. In some instances, the production operations are configured to apply hot melt adhesives to an advancing web in pre-determined patterns. These operations may include the use of systems and methods such as slot die coating, direct gravure, offset gravure and reverse gravure roll coating processes that are extensively described in the art. However, current systems and methods for applying patterned adhesives to an advancing substrate may have certain limitations.

For example, in the manufacture of absorbent articles such as feminine hygiene pads, baby diapers, and adult incontinence pads, the use of gravure coating processes may be confounded by contamination of the impression cylinders by fibers separated from the substrates to be coated. Some problems associated with gravure cavities and incomplete fluid transfer are described, for example, in U.S. Pat. Nos. 7,611, 582 B2 and 6,003,513. In some instances, slot die coating may be used for patterned coating of webs in the manufacture of absorbent products. The use of combed shims in slot die transfer processes can provide fine resolution and precise transfer of fluid to the receiving substrate in the axis transverse to the direction of web travel. Such slot transfer processes may also be configured with electro-pneumatic switching valves to intermittently transfer adhesive to an advancing substrate. However, the quality and precision of intermittent transfer of fluids to an advancing substrate may be limited by the speed of the on/off cycle of switching valves used to interrupt the flow of fluid to the slot die of the fluid applicator. Thus, as web processing speeds increase, the ability of current slot die coating methods to achieve fine resolution of on/off coat patterns in the direction of web travel

2

decreases. Consequently, it would be beneficial to provide apparatuses and methods that apply adhesives and other fluids to a substrate in patterns with relatively high resolution and high speeds without being limited by the speed of on/off cycling of switching valves used to interrupt the flow of fluid to the slot die of the fluid applicator.

SUMMARY OF THE INVENTION

Aspects of the methods and apparatuses herein involve applying fluids onto an advancing substrate. The apparatuses and methods herein may provide for the application of viscous fluids, such as adhesives, in pre-determined patterns to an advancing substrate. The fluid application apparatus may include a slot die applicator and a substrate carrier. The slot die applicator may include a slot opening, a first lip, and a second lip, the slot opening located between the first lip and the second lip. And the substrate carrier may be adapted to advance the substrate past the slot die applicator as the slot die applicator discharges adhesive onto the substrate. In operation, when a first surface of the substrate is disposed on the substrate carrier, the substrate carrier advances a second surface of the substrate past the slot opening of the slot die applicator.

In one form, an apparatus applies a fluid in a pattern to an advancing substrate, the substrate having an unconstrained caliper, H_s , and having a first surface disposed opposite of a second surface. The apparatus includes: a slot die applicator including a slot opening, a first lip, and a second lip, the slot opening located between the first lip and the second lip; a substrate carrier adapted to advance the substrate past the slot die applicator, wherein when the first surface of the substrate is disposed on the substrate carrier, the substrate carrier is adapted to advance the second surface of the substrate past the slot opening of the slot die applicator, the substrate carrier comprising: a non-compliant support surface; and a compliant pattern element, wherein the compliant pattern element includes a pattern surface, and wherein the compliant pattern element protrudes outward relative to the non-compliant support surface to define a first minimum distance, R_1 , between the pattern surface and the non-compliant support surface; wherein the substrate carrier is positioned adjacent the slot die applicator to define a minimum distance, H_g , between the pattern surface of the pattern element and the first lip and the second lip that is less than the unconstrained caliper, H_s , of the substrate; wherein as the substrate carrier advances the second surface of the substrate past the slot opening, the compliant pattern element is advanced such that the pattern surface repeatedly advances past the first lip, the slot opening, and the second lip of the slot die applicator; and wherein the pattern surface is deflected away from the slot die applicator as the pattern surface advances along the first lip, the slot opening, and the second lip of the slot die applicator to define a second minimum distance, R_2 , between the pattern surface and the non-compliant support surface, such that R_2 is less than R_1 .

In another form, a method may be used to apply a fluid discharged from a slot die applicator to a substrate in a pattern, the slot die applicator including a slot opening, a first lip, and a second lip, the slot opening located between the first lip and the second lip; and the substrate having a first surface disposed opposite of a second surface and an unconstrained caliper, H_s . The method includes the steps of: continuously advancing the substrate in a machine direction; engaging the substrate with a substrate carrier, the substrate carrier comprising: a non-compliant support surface and a pattern element, the pattern element including a pattern surface, wherein

3

pattern element extends away from the non-compliant support surface to define a first minimum distance, R1, between the pattern surface and the non-compliant support surface; positioning the substrate carrier adjacent the slot die applicator to define a minimum distance, Hg, between the pattern surface of the pattern element and the first lip and the second lip that is less than the unconstrained caliper, Hs, of the substrate; advancing the second surface of the substrate past the slot die applicator while the first surface of the substrate is disposed on the substrate carrier; intermittently deflecting the pattern surface toward the non-compliant support surface such to define a second minimum distance, R2, between the pattern surface and the non-compliant surface, wherein R2 is less than R1, by advancing the substrate and the pattern element past the first lip, the slot opening, and the second lip of the slot die applicator while the first surface of the substrate is disposed on the substrate carrier; and discharging fluid from the slot opening of the slot die applicator onto the second surface of the substrate.

In yet another form, an absorbent article includes: a top-sheet; a backsheet connected with the topsheet, the backsheet comprising a film; an absorbent core positioned between the topsheet and the backsheet; and a slot coated adhesive positioned on the film, wherein the adhesive is arranged in discrete pattern areas having shapes that correspond with shapes of pattern surfaces on a substrate carrier, the pattern areas separated by distances, dp, along a machine direction MD that corresponds with distances between adjacent pattern surfaces on a substrate carrier, and wherein each pattern area has a varying thickness that defines a cross-sectional profile along the machine direction MD, whereby each pattern area includes a leading end portion and a trailing end portion separated by a central portion, the leading end portion defining a first thickness, t1, the central portion defining a second thickness, t2, and the trailing end portion defining a third thickness, t3, and wherein t1 is greater than t2 and t3, and t2 is substantially equal to t3.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of a fluid application apparatus positioned adjacent to an advancing substrate.

FIG. 1A is a side view of a fluid application apparatus depositing fluid onto an advancing substrate in a first example pattern.

FIG. 1B is a side view of a fluid application apparatus depositing fluid onto an advancing substrate in a second example pattern.

FIG. 1C is a side view of a fluid application apparatus depositing fluid onto an advancing substrate in a third example pattern.

FIG. 1D is a side view of a fluid application apparatus depositing fluid onto an advancing substrate in a fourth example pattern.

FIG. 2A is a perspective view of an embodiment of a substrate carrier including a pattern roller having a continuous base surface and a plurality of pattern surfaces.

FIG. 2B is a detailed cross-sectional view of the substrate carrier shown in FIG. 2A taken along the line 2B-2B.

FIG. 2C is a top side view of a substrate showing a first example adhesive pattern thereon.

FIG. 3A is a perspective view of an embodiment of a substrate carrier including a pattern roller having a continuous pattern surface and plurality of base surfaces.

FIG. 3B is a detailed cross-sectional view of the substrate carrier shown in FIG. 3A taken along the line 3B-3B.

4

FIG. 3C is a top side view of a substrate showing a second example adhesive pattern thereon.

FIG. 4 is a schematic cross-sectional side view of an example substrate carrier.

FIG. 4A1 is a detailed view of the substrate carrier of FIG. 4 including a compliant pattern element and a compliant base layer connected with a base roll.

FIG. 4A2 is a detailed view of the pattern surface of the pattern element from FIG. 4A1 deflected by a force or forces applied to the pattern surface.

FIG. 4B1 is a detailed view of the substrate carrier of FIG. 4 including a non-compliant pattern element and a compliant base layer connected with a base roll.

FIG. 4B2 is a detailed view of the pattern surface of the pattern element from FIG. 4B1 deflected by a force or forces applied to the pattern surface.

FIG. 4C1 is a detailed view of the substrate carrier of FIG. 4 including a compliant pattern element connected with a base roll.

FIG. 4C2 is a detailed view of the pattern surface of the pattern element from FIG. 4C1 deflected by a force or forces applied to the pattern surface.

FIG. 5 is a schematic cross-sectional side view of a fluid application apparatus.

FIG. 6A is a detailed cross-sectional view of the substrate carrier of FIG. 5 without the substrate wherein the pattern surface of a pattern element is adjacent a first lip, a second lip, and slot opening of the slot die applicator.

FIG. 6B is a detailed cross-sectional view of a substrate carrier and a substrate advancing past a slot die applicator and showing the substrate between a slot opening of the slot die applicator and an advancing base surface.

FIG. 6C is a detailed cross-sectional view of the substrate carrier and substrate of FIG. 6B wherein the base surface is advancing past the slot opening of the slot die applicator such that the substrate is between the slot opening of the slot die applicator and a leading edge of an advancing pattern surface.

FIG. 6D is a detailed cross-sectional view of the substrate carrier and substrate of FIG. 6C wherein the base surface has advanced past the slot opening of the slot die applicator such that the substrate is between the slot opening of the slot die applicator and an advancing pattern surface.

FIG. 6E is a detailed cross-sectional view of the substrate carrier and substrate of FIG. 6D wherein the pattern surface has advanced past the slot opening of the slot die applicator.

FIG. 7 is a schematic cross-sectional side view of an embodiment of a fluid application apparatus with a substrate carrier including a pattern belt.

FIG. 8 is a schematic cross-sectional side view of another embodiment of a fluid application apparatus with a substrate carrier including a pattern belt.

FIG. 9 is a schematic cross-sectional side view of another embodiment of a fluid application apparatus with a substrate carrier including a pattern belt and a backup plate.

FIG. 10A is a top plan view of a fluid applied in a pattern to a substrate.

FIG. 10B is a cross sectional view of the substrate and fluid shown in FIG. 10A taken along line 10B-10B.

FIG. 11 is a top plan view of a disposable absorbent article.

DETAILED DESCRIPTION OF THE INVENTION

The following term explanations may be useful in understanding the present disclosure:

“Absorbent article” is used herein to refer to consumer products whose primary function is to absorb and retain soils and wastes. Non-limiting examples of absorbent articles

include diapers, training pants, pull-on pant-type diapers, refastenable diapers or pant-type diapers, incontinence briefs and undergarments, diaper holders and liners, feminine hygiene garments such as panty liners, absorbent inserts, and the like.

"Diaper" is used herein to refer to an absorbent article generally worn by infants and incontinent persons about the lower torso.

The term "disposable" is used herein to describe absorbent articles which generally are not intended to be laundered or otherwise restored or reused as an absorbent article (e.g., they are intended to be discarded after a single use and may also be configured to be recycled, composted or otherwise disposed of in an environmentally compatible manner).

The term "disposed" is used herein to mean that an element(s) is formed (joined and positioned) in a particular place or position as a macro-unitary structure with other elements or as a separate element joined to another element.

As used herein, the term "joined" encompasses configurations whereby an element is directly secured to another element by affixing the element directly to the other element, and configurations whereby an element is indirectly secured to another element by affixing the element to intermediate member(s) which in turn are affixed to the other element.

The term "substrate" is used herein to describe a material which is primarily two-dimensional (i.e. in an XY plane) and whose thickness (in a Z direction) is relatively small (i.e. $\frac{1}{10}$ or less) in comparison to its length (in an X direction) and width (in a Y direction). Non-limiting examples of substrates include a layer or layers or fibrous materials, films and foils such as plastic films or metallic foils that may be used alone or laminated to one or more web, layer, film and/or foil. As such, a web is a substrate.

The term "nonwoven" refers herein to a material made from continuous (long) filaments (fibers) and/or discontinuous (short) filaments (fibers) by processes such as spunbonding, meltblowing, and the like. Nonwovens do not have a woven or knitted filament pattern.

The term "machine direction" (MD) is used herein to refer to the direction of material flow through a process. In addition, relative placement and movement of material can be described as flowing in the machine direction through a process from upstream in the process to downstream in the process.

The term "cross direction" (CD) is used herein to refer to a direction that is generally perpendicular to the machine direction.

The terms "elastic" and "elastomeric" as used herein refer to any material that upon application of a biasing force, can stretch to an elongated length of at least about 110% of its relaxed, original length (i.e. can stretch to 10% more than its original length), without rupture or breakage, and upon release of the applied force, recovers at least about 40% of its elongation. For example, a material that has an initial length of 100 mm can extend at least to 110 mm, and upon removal of the force would retract to a length of 106 mm (40% recovery). The term "inelastic" refers herein to any material that does not fall within the definition of "elastic" above.

The term "extensible" as used herein refers to any material that upon application of a biasing force, can stretch to an elongated length of at least about 110% of its relaxed, original length (i.e. can stretch to 10%), without rupture or breakage, and upon release of the applied force, shows little recovery, less than about 40% of its elongation.

The terms "activating", "activation" or "mechanical activation" refer to the process of making a substrate, or an elastomeric laminate more extensible than it was prior to the process.

"Live Stretch" includes stretching elastic and bonding the stretched elastic to a substrate. After bonding, the stretched elastic is released causing it to contract, resulting in a "corrugated" substrate. The corrugated substrate can stretch as the corrugated portion is pulled to about the point that the substrate reaches at least one original flat dimension. However, if the substrate is also elastic, then the substrate can stretch beyond the relaxed length of the substrate prior to bonding with the elastic. The elastic is stretched at least 25% of its relaxed length when it is bonded to the substrate.

As used herein, the term "unconstrained caliper" refers to the caliper of the substrate measured according to Edana WSP 120.1 (05), with a circular presser foot having a diameter of 25.40 ± 0.02 mm and an applied force of 2.1 N (i.e. a pressure of 4.14 ± 0.21 kPa is applied).

As used herein, the term "compliant" refers to any material with a durometer hardness of 90 or less as measured according to ASTM International Designation: D2240-05 (Reapproved 2010) for Type M durometers.

As used herein, the term "non-compliant" refers to any material with a hardness value greater than 100 HRBW as defined on the Rockwell B Scale in the American National Standard Designation.

Aspects of the present disclosure involve methods and apparatuses utilizing continuous substrates for manufacturing articles, and more particularly, methods and apparatuses for applying fluids onto an advancing substrate. Particular embodiments of the apparatuses and methods disclosed herein provide for the application of viscous fluids, such as adhesives, and in some embodiments, the application of adhesives in pre-determined patterns to an advancing substrate. Embodiments of a fluid application apparatus are discussed in more detail below in the context of applying adhesives to an advancing substrate having an unconstrained caliper, H_s , and having a first surface disposed opposite of a second surface. The fluid application apparatus may include a slot die applicator and a substrate carrier. The slot die applicator may include a slot opening, a first lip, and a second lip, the slot opening located between the first lip and the second lip. And the substrate carrier may be adapted to advance the substrate past the slot die applicator as the slot die applicator discharges adhesive onto the substrate. In operation, when the first surface of the substrate is disposed on the substrate carrier, the substrate carrier advances the second surface of the substrate past the slot opening of the slot die applicator. It is to be appreciated that the apparatus and processes disclosed herein may be used to apply various types of fluids and adhesives in various different patterns to an advancing substrate other than those described and depicted herein.

As discussed in more detail below, the substrate carrier may include a base surface and a pattern element. The pattern element includes a pattern surface and protrudes outward from the base surface. As such, in substrate carriers configured with a base surface, the pattern surface and the base surface are separated by a distance, H_p . In addition, the substrate carrier is positioned adjacent the slot die applicator to define a minimum distance, H_g , between the pattern surface of the pattern element and the first lip and the second lip that is less than the unconstrained caliper, H_s , of the substrate, wherein a sum of the distance, H_p , and distance, H_g , is greater than the unconstrained caliper, H_s , of the substrate. Thus, as the substrate carrier advances the second surface of the substrate past the slot opening, the pattern element is advanced

7

such that the pattern surface repeatedly advances past the first lip, the slot opening, and the second lip of the slot die applicator. As discussed below, the pattern element and/or the base surface of the substrate carrier may be compliant or compressible. And as such, the pattern element and/or the base surface of the substrate carrier is intermittently compressed as the substrate advances between the slot die applicator and the pattern surface. As such, the pattern surface of the pattern element deflects away from the slot die applicator as the substrate and the pattern element advance past the first lip, the slot opening, and the second lip of the slot die applicator. As the pattern surface is intermittently deflected away from the slot die applicator, adhesive discharged from the slot die applicator is applied onto the second surface of the advancing substrate. More particularly, the adhesive is applied to the substrate in an area having a shape that is substantially the same as a shape defined by the pattern surface.

The apparatuses and methods disclosed herein may include substrate carriers having various configurations. For example, in some embodiments the substrate carrier may be configured as a roller. In other embodiments, the substrate carrier may include an endless belt. The substrate carriers may also utilize various outer surface arrangements. For example, the base surface may be configured as a continuous surface and the substrate carrier may include a plurality of discrete pattern elements separated from each other by the continuous surface. In such a configuration, each pattern element may include a pattern surface and each pattern element may protrude outward from the continuous surface such that each pattern surface is separated from the continuous surface by the distance, H_p . In another example, the pattern surface may be configured as a continuous surface and the base surface may include a plurality of discrete base surfaces separated from each other by the pattern element. In such a configuration, the pattern element may protrude outward from each of the base surfaces such that each base surface is separated from the continuous surface by the distance, H_p . It is to be appreciated that the pattern surface of the pattern element may be configured in various different shapes and sizes and may be configured to define various different patterns. As such, adhesive may be transferred from the slot die applicator to define various patterns on a substrate.

As mentioned above, apparatuses and methods of the present disclosure may be utilized to apply adhesives to continuous substrates used in the manufacture of absorbent articles. Such substrates may be utilized in absorbent article components such as, for example: backsheet, topsheet, absorbent cores, front and/or back ears, fastener components, and various types of elastic webs and components such as leg elastics, barrier leg cuff elastics, and waist elastics. Exemplary descriptions of absorbent article components and substrates are provided below with reference to FIG. 11. In addition, substrates may include continuous webs of material and component parts mounted on carrier substrates or may be in the form of a continuous substrate.

Although much of the present disclosure is provided in the context of manufacturing absorbent articles, it is to be appreciated that the apparatuses and methods disclosed herein may be applied to the manufacture of other types of articles and products manufactured from continuous substrates. Examples of other products include absorbent articles for inanimate surfaces such as consumer products whose primary function is to absorb and retain soils and wastes that may be solid or liquid and which are removed from inanimate surfaces such as floors, objects, furniture and the like. Non-limiting examples of absorbent articles for inanimate surfaces include dusting sheets, pre-moistened wipes or pads, pre-

8

moistened cloths, paper towels, dryer sheets and dry-cleaning clothes such. Additional examples of products include absorbent articles for animate surfaces whose primary function is to absorb and contain body exudates and, more specifically, devices which are placed against or in proximity to the body of the user to absorb and contain the various exudates discharged from the body. Non-limiting examples of incontinent absorbent articles include diapers, training and pull-on pants, adult incontinence briefs and undergarments, feminine hygiene garments such as panty liners, absorbent inserts, and the like, toilet paper, tissue paper, facial wipes or clothes, and toilet training wipes. Still other examples of products may include packaging components and substrates and/or containers for laundry detergent and coffee, which may be produced in pellets or pouches and may be manufactured in a converting or web process or even discreet products produced at high speed such as high-speed bottling lines, cosmetics, razor blade cartridges, and disposable consumer batteries.

FIG. 1 shows a perspective view an embodiment of an apparatus 100 for applying adhesives to a substrate. The apparatus 100 includes a slot die applicator 102 and a substrate carrier 104. As shown in FIG. 1, a substrate 106 is advancing in a machine direction and is partially wrapped around the substrate carrier 104. More particularly, the substrate 106 includes a first surface 108 disposed opposite a second surface 110. And the first surface 108 of the substrate 106 is disposed on an outer surface 112 of the substrate carrier 104 while the second surface 110 of the substrate 106 advances past the slot die applicator 102. As discussed in more detail below, the second surface 110 of the substrate 106 advances past the slot die applicator 102 and adhesive is transferred from the slot die applicator 102 onto the second surface of the substrate in a pattern that is substantially the same as a pattern defined on the outer surface 112 of the substrate carrier 104. As discussed in more detail below, the substrate carrier 104 may be configured in various ways to deposit fluid 130 discharged from a slot die applicator 102 onto a substrate 106 in various different patterns, such as shown for example in FIGS. 1A through 1D.

It is to be appreciated that the slot die applicator 102 shown in FIG. 1 is a generic representation of a device that is used to apply adhesive to the substrate 106. The slot die applicator may include a slot opening 114, a first lip 116, and a second lip 118. The first lip 116 may also be referred to herein as an upstream die lip, and the second lip 118 may also be referred to herein as a downstream die lip. The slot opening 114 is located between the first lip 116 and the second lip 118. Adhesive or other fluid may be discharged from the slot opening 114 onto the second surface 110 of the substrate 106 as the substrate carrier 104 advances the substrate past the first lip 116, slot opening 114, and second lip 118 of the slot die applicator 102. As discussed in more detail below, the substrate 106 is also intermittently compressed between the slot die applicator 102 and substrate carrier 104 as the substrate 106 advances past the slot die applicator 102. It is to be appreciated that various forms of slot die applicators may be used herein to apply adhesive or other fluids to an advancing substrate according to methods and apparatuses. For example, U.S. Pat. No. 7,056,386 provides a description of slot die applicators that may be used. Other examples of commercially available slot die applicators include Nordson Corporation's EP11 Series of Slot Die Applicators and ITW Dynatec GmbH's APEX Series of Slot Die Auto Adhesive Applicators.

Various types of substrate carriers 104 may be used in accordance with the apparatuses and methods herein. For example, FIGS. 2A and 2B show an embodiment of a sub-

strate carrier **104** configured as a roller **120** adapted to advance a substrate **106** past the slot die applicator **102**. The outer surface **112** of the substrate carrier **104** shown in FIGS. **2A** and **2B** includes a plurality of pattern elements **122** that protrude radially outward from a base surface **124**. Each pattern element **122** includes a pattern surface **126**, and the radial protrusion of the pattern elements **122** from the base surface **124** define a distance, H_p , between the pattern surface **126** and the base surface **124**. As shown in FIGS. **2A** and **2B**, the base surface **124** is configured as a continuous surface **128**, and the plurality of discrete pattern elements **122** are separated from each other by the continuous surface **128**. The pattern surfaces **126** in FIGS. **2A** and **2B** define a diamond shape. In some embodiments, the shape and size of the pattern surface **126** of each pattern element **122** may be identical or substantially identical to each other. It is to be appreciated that the number, size, and shape of some or all the pattern surfaces and/or pattern elements may be different. In addition, the distance, H_p , between the base surface **124** and the pattern surface **126** of the pattern element **122** may be the same or different for some or all of the pattern elements.

As discussed in more detail below, as the substrate carrier **104** advances the substrate **106** past the slot die applicator **102**, fluid discharged from the slot die applicator is deposited onto the substrate in a pattern substantially matching the shapes of the pattern surfaces on the substrate carrier. For example, FIG. **2C** shows an example pattern of fluid **130** deposited on a second surface **110** of a substrate **106** after being advanced past a slot die applicator while disposed on a substrate carrier having pattern elements **122** and pattern surfaces **126** similar to those shown in FIGS. **2A** and **2B**. As shown in FIG. **2C**, the fluid **130** is deposited onto the substrate **106** in discrete pattern areas **132** having diamond shapes that correspond with and may mirror the shapes of the pattern surfaces **126** on the substrate carrier **104** shown in FIG. **2A**.

FIGS. **3A** and **3B** show another embodiment of a substrate carrier **104** configured as a roller **120** adapted to advance a substrate **106** past the slot die applicator **102**. The substrate carrier **104** shown in FIGS. **3A** and **3B** includes a single pattern element **122** including a pattern surface **126**. And the pattern element **122** protrudes radially outward from a plurality of base surfaces **124**. More particularly, the pattern surface **126** is configured as a continuous surface **134** and the plurality of base surfaces are separated from each other by the pattern element **122**. The radial protrusion of the pattern element **122** from the base surfaces **124** defines a distance, H_p , between the pattern surface **126** and the base surfaces **124**. The pattern surface **126** in FIGS. **3A** and **3B** defines a continuous crossing line pattern wherein the shape and size of each base surface **124** are identical or substantially identical to each other. It is to be appreciated that the number, size, and shape of some or all the base surfaces may be different. In addition, the distance, H_p , between the base surfaces **124** and the pattern surface **126** of the pattern element **122** may be the same or different for some or all of the base surfaces. It should also be appreciated that the substrate carrier may be configured without base surfaces. For example, the substrate carrier may include a plurality of holes and the pattern surface may be configured as a continuous surface wherein the plurality of holes are separated from each other by the pattern element.

As previously mentioned, as the substrate carrier **104** advances the substrate **106** past the slot die applicator **102**, fluid **130** discharged from the slot die applicator **102** is deposited onto the substrate **106** in a pattern substantially matching the shape of the pattern surface **126** on the substrate carrier **104**. For example, FIG. **3C** shows an example pattern of fluid **130** deposited on a second surface **110** of a substrate **106** after

being advanced past a slot die applicator **102** while disposed on a substrate carrier **104** having a pattern element **122** and pattern surface **126** similar to that shown in FIGS. **3A** and **3B**. As shown in FIG. **3C**, the fluid **130** is deposited onto the substrate **106** in a crossing line pattern defining diamond shapes therebetween that correspond with and may mirror the shapes of the base surfaces **124** on the substrate carrier **104** shown in FIGS. **3A** and **3B**.

As previously mentioned, the substrate carrier may be constructed in various ways such that the base surface and/or pattern elements may include compliant materials. In some configurations, the compliant material(s) may be compressible to allow a pattern surface of a pattern element to deflect away from the slot die applicator. Thus, the substrate carrier may be configured such that deflection of the pattern surface away from the slot die applicator compresses the pattern element and/or base surface as the substrate and the pattern element advance past the first lip, the slot opening, and the second lip of the slot die applicator.

FIG. **4** shows a schematic cross-sectional side view of an example substrate carrier **104** that may be configured with compliant materials and components that can be compressed and allow the pattern surface **126** to deflect in response to a force or forces, F , exerted on the pattern surface **126**. The substrate carrier **104** in FIG. **4** is in the form of a roller **120** adapted to rotate around an axis of rotation **105**. In operation, a force or forces, F , may be exerted on the pattern surface **126** as the substrate **106** and the pattern element **122** advance past the first lip **116**, the slot opening **114**, and the second lip **118** of the slot die applicator **102**. It is to be appreciated that the substrate carrier **104** may be configured in various ways with various different components of compliant materials that allow the pattern surface **126** to deflect.

For example, FIGS. **4A1** and **4A2** show a detailed view of the substrate carrier **104** in the form of a roller **120**, such as from FIG. **4**, including a compliant pattern element **122** and a compliant base surface **124** connected with a base roll **160** having a non-compliant support surface **162**. More particularly, the roller **120** in FIGS. **4A1** and **4A2** may include a base layer **164** of compliant material extending radially outward from the non-compliant support surface **162** to define the compliant base surface **124**. In some arrangements, the base layer **164** of compliant material may be formed as a cylindrically shaped sleeve or tube **166** having an inner radial surface **168** and an outer radial surface **170**. The inner radial surface **168** may surround all or a portion of the non-compliant support surface **162** of the base roll **160**, and the outer radial surface **170** may define all or a portion of the base surface **124**. In turn, the pattern element **122** may include a proximal end portion **172** and a distal end portion **174** that includes the pattern surface **126**, wherein the proximal end portion **172** is connected with outer radial surface **170** of the base layer **164**. As such, the pattern element **122** may extend radially outward from the base layer **164** of compliant material to the distal end portion **174**. It is to be appreciated that the pattern element **122** may be separately connected with or integrally formed with the compliant base layer **164**. FIG. **4A1** shows the pattern element **122** and base layer **164** of compliant material in an uncompressed state, wherein the minimum distance between the pattern surface **126** and the non-compliant support surface **162** is defined by distance, R_1 . FIG. **4A2** shows the compliant pattern element **122** and compliant base layer **164** of FIG. **4A1** in a compressed state wherein a force or forces, F , are applied to the pattern surface **126**. Because the pattern element **122** and base layer **164** are both compliant, the force or forces, F , applied to the pattern surface **126** causes the pattern element **122** and the base layer **164** to be com-

11

pressed against the non-compliant surface **162** of the base roll **160**. The compression of the pattern element **122** and the base layer **164** allows the pattern surface **126** to deflect in response to the forces, *F*. As such, the minimum distance between the pattern surface **126** and the non-compliant surface **162** is defined as distance, *R2*, wherein *R2* is less than *R1*.

In another example, FIGS. **4B1** and **4B2** show a detailed view of the substrate carrier **104** in the form of a roller **120**, such as from FIG. **4**, including a non-compliant pattern element **122** and a compliant base surface **124** connected with a base roll **160** having a non-compliant support surface **162**. More particularly, the roller **120** in FIGS. **4B1** and **4B2** may include a base layer **164** of compliant material extending radially outward from the non-compliant support surface **162** to define the compliant base surface **124**. In some arrangements, the base layer **164** of compliant material may be formed as a cylindrically shaped sleeve or tube **166** having an inner radial surface **168** and an outer radial surface **170**. The inner radial surface **168** may surround all or a portion of the non-compliant support surface **162** of the base roll **160**, and the outer radial surface **170** may define all or a portion of the base surface **124**. In turn, the pattern element **122** may include a proximal end portion **172** and a distal end portion **174** that includes the pattern surface **126**, wherein the proximal end portion **172** is connected with outer radial surface **170** of the base layer **164**. As such, the pattern element **122** may extend radially outward from the base layer **164** of compliant material to the distal end portion **174**. It is to be appreciated that the pattern element **122** may be separately connected with or integrally formed with the compliant base layer **164**. FIG. **4B1** shows the base layer **164** of compliant material in an uncompressed state, wherein the minimum distance between the pattern surface **126** and the non-compliant support surface **162** is defined by distance, *R1*. FIG. **4B2** shows the compliant base layer **164** of FIG. **4B1** in a compressed state wherein a force or forces, *F*, are applied to the pattern surface **126**. Because the pattern element **122** is non-compliant and the base layer **164** is compliant, the force or forces, *F*, applied to the pattern surface **126** causes the pattern element **122** to push against the base layer **164** such that the base layer **164** is compressed between the pattern element **122** and the non-compliant surface **162** of the base roll **160**. The compression of the base layer **164** allows the pattern surface **126** to deflect in response to the force or forces, *F*. As such, the minimum distance between the pattern surface **126** and the non-compliant surface **162** is defined as distance, *R2*, wherein *R2* is less than *R1*.

In yet another example, FIGS. **4C1** and **4C2** show a detailed view of the substrate carrier **104** in the form of a roller **120** from FIG. **4** including a compliant pattern element **122** connected with a base roll **160**. The base roll **160** includes a non-compliant outer circumferential support surface **162** that also defines the base surface **124**. In turn, the pattern element **122** may include a proximal end portion **172** and a distal end portion **174** that includes the pattern surface **126**, wherein the proximal end portion **172** is connected with non-compliant support surface **162**. FIG. **4C1** shows the pattern element **122** in an uncompressed state, wherein the minimum distance between the pattern surface **126** and the non-compliant support surface **162** is defined by distance, *R1*. FIG. **4C2** shows the pattern element **122** of FIG. **4C1** in a compressed state wherein a force or forces, *F*, are applied to the pattern surface **126**. Because the pattern element **122** is compliant, the force or forces, *F*, applied to the pattern surface **126** causes the pattern element **122** to be compressed against the non-compliant support surface **162** of the base roll **160**. The compression of the pattern element **122** allows the pattern surface **126**

12

to deflect in response to the force or forces, *F*. As such, the minimum distance between the pattern surface **126** and the non-compliant support surface **162** is defined as distance, *R2*, wherein *R2* is less than *R1*. In some instances, the force or forces, *F*, may be exerted in a radial direction toward the axis of rotation **105**.

As previously mentioned, the methods and apparatuses herein include a substrate carrier adapted to advance a substrate past a slot die applicator. FIG. **5** shows a schematic cross-sectional side view of an embodiment of a fluid application apparatus **100** including a substrate carrier **104** and a slot die applicator **102**. The substrate **106** includes a first surface **108** and a second surface **110** disposed opposite the first surface **108**. A portion of the first surface **108** of the substrate **106** is disposed on the substrate carrier **104**, which may be configured as a roller **120** having a plurality of pattern elements **122** protruding from a plurality of base surfaces **124**. It is to be appreciated that the substrate carrier **104** shown in FIG. **5** may be configured with various features and aspects of any substrate carriers discussed herein, including those discussed above with reference to FIGS. **1** through **4C2**. The roller **120** rotates to advance the second surface **110** of the substrate **106** past the slot die applicator **102**. A fluid delivery system **138** may be used to supply fluid **130**, such as an adhesive, to the slot die applicator **102**. It is to be appreciated that the fluid delivery system may be configured in various different ways. For example, as shown in FIG. **5**, the fluid delivery system **138** may include a pump **140** to move fluid from a tank **142** to the slot die applicator **102**. The fluid delivery system **138** may also be configured with a pressure relief valve **144** configured to help control the pressure of the fluid **130** fed from the pump **140**. Fluid **130** from the fluid delivery system **138** passes through the slot die applicator **102** and slot opening **114** and is transferred to the second surface **110** of the advancing substrate **106**.

With continued reference to FIG. **5**, fluid **130** passing from the slot die applicator **102** is transferred to the second surface **110** of the substrate **106** in a pattern or shape that is substantially the same as the pattern surfaces **126** on the substrate carrier **104**. As discussed in more detail below, the substrate carrier **104** is positioned adjacent the slot die applicator **102** to define a minimum distance between the pattern surface **126** and slot die applicator **102**, which is less than the unconstrained caliper of the substrate **106**. As such, the pattern element and/or base surface may be compressed to allow the pattern surface **126** of the pattern element to deflect away from the slot die applicator **102** as the substrate **106** and the pattern surface **126** of the pattern element **122** advances past the first lip **116**, the slot opening **114**, and the second lip **118** of the slot die applicator **102**. However, the minimum distance between the base surface **124** of the substrate carrier **104** and the slot die applicator **102** is greater than the unconstrained caliper of the substrate **106**. As such, the base surface **124** is not compressed as the substrate advances past the first lip **116**, the slot opening **114**, and the second lip **118** of the slot die applicator **102**. Thus, in operation, although fluid **130** is continuously discharged from the slot die applicator **102**, fluid **130** is transferred to the advancing substrate **106** when the pattern element **122** and/or base surface **124** is compressed as pattern surfaces **126** on the substrate carrier **102** advance past the slot die opening **114** and deflect the pattern surface **126**. And fluid **130** is not transferred to the advancing substrate **106** when the pattern element **122** and/or base surface **124** are uncompressed while the base surfaces **124** on the substrate carrier **104** advance past the slot die opening **114**. The following provides a more detailed description of fluid

13

transfer from the slot die applicator to the substrate with reference to FIGS. 6A through 6E.

FIG. 6A is a detailed cross-sectional view of the substrate carrier of FIG. 5 shown without the substrate wherein the pattern surface 126 of a pattern element 122 is adjacent a first lip 116, a second lip 118, and slot opening 114 of the slot die applicator 102. As shown in FIG. 6A, the substrate carrier 104 includes a non-compliant support surface 162, a base surface 124, and a pattern element 122 protruding from base surface 124. In an uncompressed state, the pattern element 122 protrudes outward from the base surface 124 to define a distance, H_p , between the pattern surface 126 and the base surface 124, and to define a minimum distance, R_1 , between the pattern surface 126 and the non-compliant support surface 162. The substrate carrier 104 is also positioned adjacent the slot die applicator 102 to define a minimum distance, H_g , between the pattern surface 126 of the uncompressed pattern element 122 and the first lip 116 and the second lip 118. As discussed below, the minimum distance, H_g , is less than the unconstrained caliper, H_s , of the substrate 106 advanced by the substrate carrier 104. In addition, the substrate carrier 104 is positioned adjacent the slot die applicator 102 to define a minimum distance, H_b , between the base surface 124 and the first lip 116 and the second lip 118. As discussed below, the minimum distance, H_b , may be greater than the unconstrained caliper, H_s , of the substrate advanced by the substrate carrier 104.

FIG. 6B is a detailed cross-sectional view of a substrate carrier 104 of FIG. 6A and a substrate 106 advancing past a slot die applicator 102. The substrate 106 has an unconstrained caliper, H_s , and has a first surface 108 disposed opposite of a second surface 110. The first surface 108 of the substrate 106 is disposed on the substrate carrier 104. And the substrate 106 and substrate carrier 104 are shown as advancing together in a machine direction, MD, past the slot die applicator 102. More particularly, the second surface 110 of the substrate 106 is advancing past a slot opening 114 located between an upstream lip 116 and a downstream lip 118 of the slot die applicator 102. As previously mentioned, the substrate carrier 104 is positioned adjacent the slot die applicator 102 to define a minimum distance, H_g , between the uncompressed pattern surface 126 of the pattern element 122 and the first lip 116 and the second lip 118 that is less than the unconstrained caliper, H_s , of the substrate 106. In addition, the substrate carrier 104 is positioned adjacent the slot die applicator 102 to define a minimum distance, H_b , between the base surface 124 and the first lip 116 and the second lip 118 that is greater than the unconstrained caliper, H_s , of the substrate. The apparatus 100 may also be configured such that a sum of the distance, H_p , and distance, H_g , is greater than the unconstrained caliper, H_s , of the substrate 106. Thus, a portion 106a of the substrate 106 that is located between the slot opening 114 of the slot die applicator 102 and the advancing base surface 124 is not pressed against the base surface 124. As such, although fluid 130 is continuously discharged from the slot opening 114, fluid 130 is not being transferred to the second surface 110 of the substrate 106.

FIG. 6C is a detailed cross-sectional view of the substrate carrier 104 and substrate 106 of FIG. 6B wherein the base surface 124 has advanced past the slot opening 114 of the slot die applicator 102 such that a portion 106b of the substrate 106 is between the first lip 116 of the slot die applicator 102 and a leading edge 146 of an advancing pattern surface 126. As previously discussed, the minimum distance, H_g , between the pattern surface 126 of the uncompressed pattern element 122 and the first lip 116 and the second lip 118 is less than the unconstrained caliper, H_s , of the substrate 106. As such, a

14

portion 106b of substrate 106 between the pattern surface 126 and the first lip 116 is pressed against and exerts forces on the pattern surface 126. Thus, the pattern element 122 and/or base surface 124 compresses, allowing the pattern surface 126 to deflect away from the first lip 116 to define a minimum distance, R_2 , between the pattern surface 126 and the non-compliant support surface 162. The fluid 130 being discharged from the slot opening 114 is shown in FIG. 6C as beginning to transfer to the second surface 110 of the substrate as the leading edge 146 of the pattern surface 126 and adjacent portion of the substrate 106 begin to advance past the slot opening 114.

With continued reference to FIG. 6C, the compression of the pattern element 122 and/or base surface 124 allows the pattern surface 126 to deflect away from the first lip 116 to define a compressed distance, H_c , between the pattern surface 126 and the first lip 116. When the substrate 106 is made from a material, such as a film, the substrate 106 may maintain a caliper that is substantially the same as the unconstrained caliper, H_s , while advancing between the pattern surface 126 and the first lip 116. Thus, the pattern surface 126 may deflect by a distance represented by the difference of H_g and H_s , and in some instances, the distance R_2 , may be calculated as:

$$R_2 = R_1 + H_g - H_s$$

In such a scenario, the compressed distance, H_c , may also be equal to or substantially equal to the unconstrained caliper, H_s .

Still referring to FIG. 6C, when the substrate 106 is made from a material, such as a nonwoven or laminate including a nonwoven layer, the substrate 106 may be compressed to a caliper that is less than the unconstrained caliper, H_s , while advancing between the pattern surface 126 and the first lip 116. In such a scenario, the compressed distance, H_c , may be less than the unconstrained caliper, H_s . In other words, the substrate 106 may be compressed to a caliper equal to or substantially equal the compressed distance, H_c . Thus, the pattern surface 126 may deflect by a distance represented by the difference of H_g and H_c , and in some instances, the distance R_2 , may be calculated as:

$$R_2 = R_1 + H_g - H_c$$

FIG. 6D is a detailed cross-sectional view of the substrate carrier 104 and substrate of FIG. 6C wherein the base surface 124 and leading edge 146 of the pattern surface 126 has advanced past the slot opening 114 of the slot die applicator 102 such that the portion 106b of the advancing substrate 106 is between the slot opening 114 of the slot die applicator 102 and an advancing pattern surface 126. Because the minimum distance, H_g , between the pattern surface 126 of the uncompressed pattern element 122 and the first lip 116 and the second lip 118 is less than the unconstrained caliper, H_s , of the substrate 106, the portion 106b of substrate 106 between the pattern surface 126 and the first lip 116 and second lip 118 of the slot die applicator 102 presses against and exerts forces on the pattern surface 126. As such, the compliant pattern element 122 and/or base surface 124 are compressed, allowing the pattern surface 126 to deflect away from the first lip 116 and second lip 118. As mentioned above, when the substrate 106 is made from a material, such as a film, the substrate 106 may maintain a caliper that is substantially the same as the unconstrained caliper, H_s , while advancing between the pattern surface 126 and the first lip 116 and second lip 118. Thus, the pattern surface 126 may deflect by a distance represented by the difference of H_g and H_s , and in some instances, the distance R_2 , may be calculated as: $R_2 = R_1 + H_g - H_s$. Also, as mentioned above, when the substrate 106 is

15

made from a material, such as a nonwoven or laminate including a nonwoven layer, the substrate **106** may be compressed to a caliper that is less than the unconstrained caliper, H_s , while advancing between the pattern surface **126** and the first lip **116** and second lip **118**. Thus, the pattern surface **126** may deflect by a distance represented by the difference of H_g and H_c , and in some instances, the distance R_2 , may be calculated as: $R_2 = R_1 + H_g - H_c$. The fluid **130** being discharged from the slot opening **114** is shown in FIG. 6D as being transferred to the second surface **110** of the substrate as the pattern surface **126** and adjacent portion **106b** of the substrate **106** advance past the slot opening **114**.

FIG. 6E is a detailed cross-sectional view of the substrate carrier **104** and substrate **106** of FIG. 6D wherein the portion **106b** of the substrate and the pattern surface **126** have advanced past the slot opening **114** of the slot die applicator **102**. As shown in FIG. 6E, an upstream portion **126a** of the pattern surface **126** is adjacent the second lip **118**, and a downstream portion **126b** of the pattern surface **126** has advanced past the second lip **118**. As such, the portion **106b** of the advancing substrate **106** between the second lip **118** of the slot die applicator **102** and the upstream portion **126a** of the advancing pattern surface **126** presses against and exerts forces on the pattern surface **126**. As such, the compliant pattern element **122** and/or base surface **124** are compressed, allowing the upstream portion **126a** of the pattern surface **126** to deflect away from the first lip **116** and second lip **118** to define the minimum distance, R_2 , between the upstream portion **126a** of the pattern surface **126** and the non-compliant support surface **162**.

With continued reference to FIG. 6E, the downstream portion **126b** of the pattern surface **126** has advanced past the second lip **118** of the slot die applicator **102**, and as such, the portion **106b** of the substrate **106** is no longer pressing against downstream portion **126b** of the pattern surface **126**, allowing the compliant pattern element **122** and/or base surface **124** to return to an uncompressed state wherein the downstream portion **126b** of the pattern surface **126** deflects back away from the non-compliant surface **162** such that the minimum distance between the non-compliant surface **162** and the downstream portion **126b** pattern surface **126** is the distance, R_1 . Once the upstream portion **126a** of the pattern surface **126** has also advanced past the second lip **118**, the remainder of the compliant pattern element **122** and/or base surface **124** may return to an uncompressed state wherein the both the upstream portion **126a** and downstream portion **126b** of the pattern surface **126** have deflected away from the non-compliant surface **162** such that the minimum distance between the non-compliant surface **162** and the pattern surface **126** is the distance, R_1 .

Still referring to FIG. 6E, an uncompressed portion **106c** of the advancing substrate **106** is between the slot opening **114** of the slot die applicator **102** and an advancing base surface **124**. Because the minimum distance, H_b , between the base surface **124** and the first lip **116** and the second lip **118** that is greater than the unconstrained caliper, H_s , of the substrate, a portion **106c** of substrate **106** that advances between the base surface **124**, slot opening **114**, and the first lip **116** of the slot die applicator **102** is uncompressed. As such, the fluid **130** being discharged from the slot opening **114** is shown in FIG. 6E as ceasing to be transferred to the second surface **110** of the substrate **106** as the base surface **124** and adjacent uncompressed portion **106c** of the substrate advance past the slot opening **114**.

As previously mentioned, various forms and configurations of substrate carriers may be used with the presently disclosed methods and apparatuses. For example, FIG. 7

16

shows a schematic cross-sectional side view of an embodiment of a fluid application apparatus **100** with a substrate carrier **104** including an endless pattern belt **148**. The pattern belt **148** is wrapped around two rollers **150** adapted to advance pattern belt **148** and substrate past the slot die applicator **102**. The pattern belt **148** may include various different combinations, shapes, and types of pattern elements **122** and base surfaces **124** and/or holes **136** as previous described. As shown in FIG. 7, the slot die applicator **102** is adjacent the pattern belt **148** at a location where the pattern belt **148** is partially wrapped around one of the rollers **150**. It is to be appreciated that the slot die applicator **102** may be located adjacent other locations of the pattern belt **148**. For example, FIG. 8 shows a schematic cross-sectional side view of an embodiment of a fluid application apparatus **100** wherein the slot die applicator **102** is adjacent the pattern belt **148** at a location between the rollers **150**. And FIG. 9 shows a schematic cross-sectional side view of the embodiment of FIG. 8 with a backup plate **152** located behind the pattern belt **148**, wherein the backup plate **148** provides support to the pattern belt **148** to help prevent the pattern belt from deflecting away from the slot die applicator **102**.

With reference to the above description and associated figures, it is to be appreciated that the apparatuses **100** herein may be used to apply adhesive **130** discharged from a slot die applicator **102** to a substrate **106** in a pattern by continuously advancing the substrate in a machine direction past a first lip **116**, second lip **118**, and slot opening **114** in the slot die applicator **102**. The substrate **106** may be engaged with a substrate carrier **104** that may include a base surface **124** and a pattern element **122**, wherein the pattern element includes a pattern surface **126**. The pattern element **122** protrudes from the base surface **124** to define a distance, H_p , between the pattern surface **126** and the base surface **124**. As previously mentioned, in some embodiments, the substrate carrier may include holes **136** instead of or in combination with base surfaces **126** adjacent the pattern element **122**. The substrate carrier **104** is positioned adjacent the slot die applicator **102** to define a minimum distance, H_g , between the pattern surface **126** of the uncompressed pattern element **122** and the first lip **116** and the second lip **118** that is less than the unconstrained caliper, H_s , of the substrate **106**. The second surface **110** of the substrate **106** may be advanced past the slot die applicator **102** while the first surface **108** of the substrate **106** is disposed on the substrate carrier **104**. And the substrate **106** is intermittently compressed between the slot die applicator **102** and the pattern surface **126** of the pattern element **122** by advancing the pattern element as the pattern surface of the pattern element advances past the first lip **116**, the slot opening **114**, and the second lip **118** of the slot die applicator **102** while the first surface **108** of the substrate **106** is disposed on the substrate carrier **104**.

It is to be appreciated that the methods and apparatuses herein may deposit fluids, such as adhesives, onto advancing a substrate advancing in a machine direction MD in various designs or patterns. For example, FIG. 10A shows fluid **130** deposited onto the second surface **110** of a substrate **106** in an example pattern defined by discrete pattern areas **132** having varying cross directional CD widths and/or cross directional CD locations. In addition, because the fluid **130** is deposited onto the substrate **106** in pattern areas **132** having shapes that correspond with and may mirror the shapes of the pattern surfaces **126** of the pattern elements **122** as discussed above, the fluid **130** may be deposited intermittently to define distances, d_p , between pattern areas **132** along the machine direction MD that correspond with the distances between adjacent pattern surfaces **126** on the substrate carrier **104**. In

17

some configurations, the fluid **130** may be deposited onto the substrate intermittently to define distances between pattern areas **132** of 30 mm or less along the machine direction of the substrate **106**. In addition, the fluid **130** may be deposited on the substrate **106** so as to create a varying thickness that defines a cross-sectional profile along the machine direction MD. For example, FIG. **10B** shows a cross-sectional view of the pattern areas **132** on the substrate **106** of FIG. **10A**. As shown in FIG. **10B** along the machine direction MD, each pattern area **132** includes a leading end portion **400** and a trailing end portion **402** separated by a central portion **404**. The leading end portion **400** defines a first thickness, t_1 , the central portion defines **404** a second thickness, t_2 , and the trailing end portion **402** define a third thickness, t_3 . In some configurations, the first thickness, t_1 , is greater than the second thickness t_2 , and the third thickness, t_3 , and the second thickness, t_2 , may be substantially the same as the third thickness, t_3 .

As previously mentioned, the apparatuses **100** and methods herein may be used to provide for the application of adhesives in patterns to substrates and components during the manufacture of various different products. For the purposes of a specific illustration, FIG. **11** shows one example of a disposable absorbent article **250**, such as described in U.S. Patent Publication No. US2008/0132865 A1, in the form of a diaper **252** that may be constructed from such substrates and components manipulated during manufacture according to the apparatuses and methods disclosed herein. In particular, FIG. **11** is a plan view of one embodiment of a diaper **252** including a chassis **254** shown in a flat, unfolded condition, with the portion of the diaper **252** that faces a wearer oriented towards the viewer. A portion of the chassis structure is cut-away in FIG. **11** to more clearly show the construction of and various features that may be included in embodiments of the diaper.

As shown in FIG. **11**, the diaper **252** includes a chassis **254** having a first ear **256**, a second ear **258**, a third ear **260**, and a fourth ear **262**. To provide a frame of reference for the present discussion, the chassis is shown with a longitudinal axis **264** and a lateral axis **266**. The chassis **254** is shown as having a first waist region **268**, a second waist region **270**, and a crotch region **272** disposed intermediate the first and second waist regions. The periphery of the diaper is defined by a pair of longitudinally extending side edges **274**, **276**; a first outer edge **278** extending laterally adjacent the first waist region **268**; and a second outer edge **280** extending laterally adjacent the second waist region **270**. As shown in FIG. **11**, the chassis **254** includes an inner, body-facing surface **282**, and an outer, garment-facing surface **284**. A portion of the chassis structure is cut-away in FIG. **11** to more clearly show the construction of and various features that may be included in the diaper. As shown in FIG. **11**, the chassis **254** of the diaper **252** may include an outer covering layer **286** including a topsheet **288** and a backsheet **290**. An absorbent core **292** may be disposed between a portion of the topsheet **288** and the backsheet **290**. As discussed in more detail below, any one or more of the regions may be stretchable and may include an elastomeric material or laminate as described herein. As such, the diaper **252** may be configured to adapt to a specific wearer's anatomy upon application and to maintain coordination with the wearer's anatomy during wear.

The absorbent article may also include an elastic waist feature **202** shown in FIG. **11** in the form of a waist band **294** and may provide improved fit and waste containment. The elastic waist feature **202** may be configured to elastically expand and contract to dynamically fit the wearer's waist. The elastic waist feature **202** can be incorporated into the diaper in

18

accordance with the methods discussed herein and may extend at least longitudinally outwardly from the absorbent core **292** and generally form at least a portion of the first and/or second outer edges **278**, **280** of the diaper **252**. In addition, the elastic waist feature may extend laterally to include the ears. While the elastic waist feature **202** or any constituent elements thereof may comprise one or more separate elements affixed to the diaper, the elastic waist feature may be constructed as an extension of other elements of the diaper, such as the backsheet **290**, the topsheet **288**, or both the backsheet and the topsheet. In addition, the elastic waist feature **202** may be disposed on the outer, garment-facing surface **284** of the chassis **240**; the inner, body-facing surface **282**; or between the inner and outer facing surfaces. The elastic waist feature **202** may be constructed in a number of different configurations including those described in U.S. Pat. No. 7,432,413; U.S. Patent Publication No. 2007/0142798; and U.S. Patent Publication No. 2007/0287983; all of which are hereby incorporated by reference herein.

As shown in FIG. **11**, the diaper **252** may include leg cuffs **296** that may provide improved containment of liquids and other body exudates. In particular, elastic gasketing leg cuffs can provide a sealing effect around the wearer's thighs to prevent leakage. It is to be appreciated that when the diaper is worn, the leg cuffs may be placed in contact with the wearer's thighs, and the extent of that contact and contact pressure may be determined in part by the orientation of diaper on the body of the wearer. The leg cuffs **296** may be disposed in various ways on the diaper **202**.

The diaper **252** may be provided in the form of a pant-type diaper or may alternatively be provided with a re-closable fastening system, which may include fastener elements in various locations to help secure the diaper in position on the wearer. For example, fastener elements may be located on the first and second ears and may be adapted to releasably connect with one or more corresponding fastening elements located in the second waist region. It is to be appreciated that various types of fastening elements may be used with the diaper.

Components of the disposable absorbent article (i.e., diaper, disposable pant, adult incontinence article, sanitary napkin, pantliner, etc.) described in this specification can at least partially be comprised of bio-sourced content as described in US 2007/0219521A1 Hird et al published on Sep. 20, 2007, US 2011/0139658A1 Hird et al published on Jun. 16, 2011, US 2011/0139657A1 Hird et al published on Jun. 16, 2011, US 2011/0152812A1 Hird et al published on Jun. 23, 2011, US 2011/0139662A1 Hird et al published on Jun. 16, 2011, and US 2011/0139659A1 Hird et al published on Jun. 16, 2011. These components include, but are not limited to, topsheet nonwovens, backsheets, backsheets nonwovens, side panel nonwovens, barrier leg cuff nonwovens, super absorbent, nonwoven acquisition layers, core wrap nonwovens, adhesives, fastener hooks, and fastener landing zone nonwovens and film bases.

In at least one exemplary configuration, a disposable absorbent article component comprises a bio-based content value from about 10% to about 100% using ASTM D6866-10, method B, in another embodiment, from about 25% to about 75%, and in yet another embodiment, from about 50% to about 60% using ASTM D6866-10, method B.

In order to apply the methodology of ASTM D6866-10 to determine the bio-based content of any disposable absorbent article component, a representative sample of the disposable absorbent article component must be obtained for testing. In at least one embodiment, the disposable absorbent article component can be ground into particulates less than about 20

mesh using known grinding methods (e.g., Wiley® mill), and a representative sample of suitable mass taken from the randomly mixed particles.

In the context of the previous discussion, the apparatuses 100 and methods herein may be used to provide for the application adhesives in patterns to substrates and components during the manufacture of an absorbent article. For example, adhesives may be applied in various patterns to portions of any of the topsheet, backsheet films, backsheet nonwovens, absorbent core, core encapsulation webs, acquisition layer, surge layer, secondary topsheet layer, leg cuffs, waist feature, ears, and fastening elements during the manufacture of an absorbent article. In some instances, the adhesive may be a different color than that of the substrate. In some applications, the apparatuses and methods herein may be adapted to apply adhesives in absorbent core assembly processes, such as described for example in U.S. Patent Publication Nos. US2006/0021695A1; US2006/0048880A1; US2008/0215166A1; and US2010/0051166A1. In some instances, the apparatuses and methods herein may be configured to apply fluid formulations in the form of wetness indicators, such as disclosed for example in U.S. Patent Publication No. US2011/0137274A1. In yet other instances, the apparatuses and methods herein may be configured to apply fastening adhesives for feminine care articles, including sanitary napkins, panty liners, adult incontinence pads, and the like, such as disclosed for example in European Patent Publication No. EP0745368A1.

The dimensions and values disclosed herein are not to be understood as being strictly limited to the exact numerical values recited. Instead, unless otherwise specified, each such dimension is intended to mean both the recited value and a functionally equivalent range surrounding that value. For example, a dimension disclosed as “40 mm” is intended to mean “about 40 mm.”

Every document cited herein, including any cross referenced or related patent or application, is hereby incorporated herein by reference in its entirety unless expressly excluded or otherwise limited. The citation of any document is not an admission that it is prior art with respect to any invention disclosed or claimed herein or that it alone, or in any combination with any other reference or references, teaches, suggests or discloses any such invention. Further, to the extent that any meaning or definition of a term in this document conflicts with any meaning or definition of the same term in a document incorporated by reference, the meaning or definition assigned to that term in this document shall govern.

While particular embodiments of the present invention have been illustrated and described, it would be obvious to those skilled in the art that various other changes and modifications can be made without departing from the spirit and scope of the invention. It is therefore intended to cover in the appended claims all such changes and modifications that are within the scope of this invention.

What is claimed is:

1. A method for applying a fluid discharged from a slot die applicator to a substrate in a pattern, the slot die applicator including a slot opening, a first lip, and a second lip, the slot opening located between the first lip and the second lip; and the substrate having a first surface disposed opposite of a second surface and an unconstrained caliper, H_s , the method comprising the steps of:
 - continuously advancing the substrate in a machine direction;
 - engaging the substrate with a substrate carrier, the substrate carrier comprising: a non-compliant support surface and a pattern element, the pattern element including a pattern surface, wherein pattern element extends away from the non-compliant support surface to define a first minimum distance, R_1 , between the pattern surface and the non-compliant support surface;
 - positioning the substrate carrier adjacent the slot die applicator to define a minimum distance, H_g , between the pattern surface of the pattern element and the first lip and the second lip that is less than the unconstrained caliper, H_s , of the substrate;
 - advancing the second surface of the substrate past the slot die applicator while the first surface of the substrate is disposed on the substrate carrier;
 - intermittently deflecting the pattern surface toward the non-compliant support surface such to define a second minimum distance, R_2 , between the pattern surface and the non-compliant surface, wherein R_2 is less than R_1 , by advancing the substrate and the pattern element past the first lip, the slot opening, and the second lip of the slot die applicator while the first surface of the substrate is disposed on the substrate carrier; and
 - discharging fluid from the slot opening of the slot die applicator onto the second surface of the substrate.
2. The method of claim 1, wherein the substrate carrier comprises a roller.
3. The method of claim 1, wherein the substrate carrier comprises an endless belt.
4. The method of claim 1, wherein the substrate carrier further comprises a compliant base surface, wherein the pattern element protrudes from the compliant base surface to define a distance, H_p , between the pattern surface and the compliant base surface.
5. The method of claim 4, wherein the substrate carrier is positioned adjacent the slot die applicator to define a minimum distance, H_g , between the pattern surface of the pattern element and the first lip and the second lip that is less than the unconstrained caliper, H_s , of the substrate; and wherein a sum of the distance, H_p , and distance, H_g , is greater than the unconstrained caliper, H_s , of the substrate.
6. The method of claim 1, wherein the fluid comprises an adhesive.
7. The method of claim 1, wherein the fluid is a different color than the substrate.

* * * * *